

DESIGN OF A MICROPROCESSOR CONTROLLED FIVE AXIS NC MACHINE

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in Partial Fulfilment of the Requirements
for the Degree of

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by

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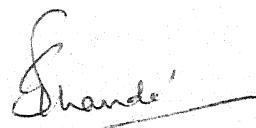
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CERTIFICATE

It is certified that this work entitled 'Design of A Microprocessor Controlled Five Axis NC Machine', by M. Krishnaswamy has been carried out under our supervision and that this work has not been submitted elsewhere for a degree.



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ABSTRACT

A microprocessor controller of a five axis NC machine with three simultaneously controlled axes has been designed. The system accepts a set of G-code instructions and drives the machine accordingly. The software and hardware have been implemented and tested successfully; the machine being simulated by a plotter. The plotter has been used in the incremental mode. The hardware consists of a SDK-86 kit, based on the intel 8086 16 bit microprocessor, a CRT with keyboard and the plotter. The software has been written in the PLM-86 language and developed in the MDS series III system and implemented as firmware in EPROM's. Some illustrative examples showing how the system can be used are also given in the present work.

CONTENTS

	Page
Chapter 1 INTRODUCTION	1
1.1 Classification of NC Systems	1
1.2 Development of Microprocessor Systems for NC	3
1.3 Point-to-Point and Contour Programming	5
1.4 Objectives and Scope	7
Chapter 2 DESIGN OF MICROCOMPUTER CONTROLLER	8
2.1 Description of Experimental Set-up	8
2.2 Drive System and Interface	11
2.3 Plotter Version	19
2.4 Design Considerations	21
Chapter 3 SOFTWARE DEVELOPMENT	22
3.1 G-Codes	22
3.2 Program Description	25
3.3 Interface to Computer-Software	29
3.4 Interface to Computer-Hardware	30
3.5 Linear and Circular Interpolation Algorithms	30
Chapter 4 TEST EXAMPLES	35
4.1 Example No.1	35
4.2 Example No.2	37
4.3 Example No.3	38

	Page
Chapter 5 CONCLUSIONS AND SUGGESTIONS	42
5.1 Technical Summary	42
5.2 Suggestions for Further Work	43
Appendix I G-CODE CONVENTIONS	45
Appendix II FLOW CHARTS	49
Appendix III PROGRAM LISTINGS	54
References	

List of Tables

Table No.	Description	Page
2.1	Sequence of excitation for stepper motor	17
2.2	Coding of incremental bytes for the Servogor plotter	20
3.1	Table of addresses	23
3.2	Special symbols and their meaning	24

List of Figures

Fig. No.	Description	Page
2.1	Block schematic of the system	12
2.2	Timer/Counter (8253) Interconnections	13
2.3	Input/Output ports schematic	14
2.4	Stepper motor drive amplifier	15
2.5	Stepper motor sequencer	16
3.1	Interface to computer	31
4.1	Example No. 1	36
4.2	Example No. 2	39
4.3	Example No. 3	40

CHAPTER 1

INTRODUCTION

1.1 Classification of NC Systems

After the introduction of NC machines which consisted only of hardware and accepted the punched paper tape as input, the mechanical automation was increasingly replaced by computer automation in NC machines. This led to the invention of a wide variety of NC systems. As these new types of machines were widely used, more tasks arose which encouraged the adoption of small or large computers to take full advantage of the possibilities offered by the concept of numerical control.

Initially computers were used off-line to compute the interpolations, offsets etc. But, as microelectronics developed fast, NC machines became available with a special-purpose computer to compute for a group of several machines. Nowadays, with the advent of microprocessors manufacturers are able to integrate the computing functions within the NC machines. As computers became common place, high level part programming languages and compilers were available. Now, there are NC machines which have the part programming interpreter built into the machine itself, which eliminate the need of using a main-frame computer for less complex computations.

Initially, the large installation and maintenance costs of the computers forced the users to control many NC machines through one large computer. This system is called as direct numerical control (DNC) [2,3].

Controlling one NC machine through a special purpose computer is called Computer Numerical Control (CNC) [2,3]. The CNC needs just enough memory and I/O ports needed to store utility programs and user programs and to communicate with the machine tool. Hence the cost is less compared to DNC systems. Though small in its class, the micro-computer in a CNC system has enough memory storage eliminating the need for the punched tape, and providing some editing features as well as a cathode ray terminal (CRT). More programs for diagnostics, debugging, self-test etc., are also implemented in the CNC machine.

When the special purpose computer used in the CNC system is replaced by a microprocessor system, as it is being increasingly done, it becomes a micro-computer numerical control system. This system offers the advantages of low cost, reliability, low maintenance costs, and small space [1].

CNC and DNC are really forms of computer aided manufacturing (CAM). More frequently the system is also used for collecting management information like, the number of parts made, down time, set up time and types of machine failures. The

same system can be used for scheduling and inventory control.

When a computer is used to design the parts, with the help of an interactive graphics hardware and software, the process is called computer aided design (CAD) [2]. The design then will lead to automatic simulation, analysis and evaluation. This computer can then deliver the design to the CNC machine in some machine readable form, with the help of a part programmer. In such a case, the limitations imposed by the small memory storage and computational capability of CNC or micro-computer NC machines can be overcome with the addition of a communication link with a CAD environment. This link can be a simple RS-232C link or current loop or a telephone line with a modem at each end.

Such a link increases the possibilities of complex machining operations. Also, if the mainframe computer is networked with other computers, the design by a CAD environment elsewhere can be used by the local CNC machine easily. Use can also be made of the mass storage media of the mainframe computer, to store the developed part programs.

1.2 Development of Microprocessor Systems for NC

With the advent of microprocessors the computing systems for the NC machines are being implemented with fewer chips, with fewer interconnections and hence with higher reliability. The cost versus performance ratio of microprocessors has been

on the decrease ever since the introduction of the first generation of microprocessors, i.e., intel 8008, in the year 1971 [1] concurrently the memory chips, peripheral chips and other logic chips have been improved in performance, reliability and cost. Now 16-bit and even 32-bit microprocessors are available so that the computations which were earlier done in a large computer can now be done in the CNC machine itself.

Present day microprocessors fulfil all the requirements of the CNC machine, like speed, memory capacity and computational capability. Even the generation of the timing signals and the feed frequency can be realised through the software in the μ P system. If more computational time is needed for arithmetic operations, it is possible to use one or two peripheral chips to do the same job of controlling the drives. The development of the system is based on the considerations like the maximum cutting speed, the number of simultaneously controlled axes, the interpolation accuracy needed and the interaction between the user and computer. Based on these, a compromise is struck between software and hardware to optimise speed and cost.

The μ P system for NC is designed after finalising the hardware-software compromise. The hardware consists of the CPU, control chips (if needed), memory, Input/Output chips and the drive interfaces. The basic hardware can be tested with the

help of a logic analyzer. The software is developed concurrently in a micro-computer development system (MDS). The bugs can be removed using the debugging package in the MDS. Then the software is written into or 'burnt' into EPROM memory chips and can be installed in the hardware. The MDS has an in-circuit-emulator (ICE) which is used to debug the hardware and software simultaneously. After the hardware and software are ready, test data can be input into the microcomputer and the system performance evaluated.

1.3 Point-to-Point and Contour Programming

There are two types of numerical control, each used for a different kind of machine operation. One is called point-to-point, or positioning control, and the other is called contouring, or continuous path numerical control [2,3].

In the point-to-point numerical control the cutting tool or the work table is moved to a specific position as called for on the part program and an operation like drilling of a hole is performed. A simple drilling machine follows this type of control. The exact path taken by the tool is immaterial, and only care should be taken such that the spindle does not collide with either the part or the holding fixtures.

Unlike the point-to-point control, contouring control requires that two or more motions of the machine be simultaneously and precisely controlled. In the contour control, each

incremental movement must be described together with its feed rate number. The entire travel must therefore be controlled to close accuracy both as to position and velocity. Milling machines are proven to be the popular application of continuous path numerical control. Most contouring machines move only in straightline movements and the circular and other cuts will be broken into short straight line segments. The breakup of a curve into these straight line segments is one of the major time consuming requirements in contour programming. Another calculation required is describing the path of the center of the cutter rather than the actual part contour dimensions. This is called the offset calculation. The problem becomes complicated as the number of simultaneously controlled axes increases.

The contouring machine has at least the linear interpolation capability. The interpolation is done either in the hardware or through software. The velocity along the cutting path should be constant irrespective of the direction of travel. The straight line is split into a number of small segments and each segment is travelled in a fixed time interval, so that the timing frequency determines the velocity of the tool cutting. The timing frequency is varied according to the feed rate required.

1.4 Objectives and Scope

In this thesis, design of a microprocessor based five axis NC machine is described. The experimental set up and the program controlling it are also described. The objective of the work is to develop a base for a microcomputer controlled machining center. Though the design is now for only G-code input, the design is done with the view of future work, like implementation of a part programming language compiler/interpreter with more interactive programming. The experimental set-up takes the G-code sequences as the input through the CRT and processes them to generate the control signals and information required by the drive system to move the tool in the required path. The set-up also generates additional signals like coolant on/off signal, spindle speed change information, spindle direction signal, annunciator signals, etc. The set-up senses various switches like manual positioning switch, emergency stop switch, hold switch, program reset switch etc., and takes appropriate action. A plotter version of the set up which controls the movement of a pen in a two axis plotter is also described.

CHAPTER 2

DESIGN OF THE μ P CONTROLLER

2.1 Description of experimental set up

The microprocessor chosen for this particular application is the 16 bit intel 8086. The selection was based on the following considerations :

The system should be capable of being modified in future to have more options and high level part programming language implementation.

It should be fast enough to do real time interpolations like for circles and complex curves in future.

The system should be designed and the software, hardware debugging should be done locally. Because of the availability of the microcomputer development system for the intel products, intel 8086 [4] was chosen to be used as the central processing unit.

The availability of the high level language PLM encouraged all the software be written in a highly readable form. The SDK-86 Kit [5] was used in place of the basic microcomputer hardware.

The RS232-C interface using the 8251 SIO chip is used in the set up to the data entry and display functions through a CRT monitor. The program is input through the keyboard with the help of a small editing facility provided in the software. After all the data are entered, the CRT displays the final version of the G-code sequence and waits for a go-ahead signal for machining, from the operator. When it is given, the machine starts moving the table according to the instructions in the G-code sequence.

Provisions in the software allow a paper tape reader to load the G-code instructions direct to the memory from a paper tape.

The intel 8253 timer/counter chips [4] are used to generate the feed frequencies for stepper motors which drive the table and also to count the number of pulses fed to the stepper motors. Each of the two 8253 chips contain three programmable timer/counters. Each of these can be programmed in a wide variety of modes.

In this application two such chips are used, one for generation of the rate signals for the stepper motors which control the velocity in each direction and the other is used for counting the steps in each direction and stopping the pulses fed to the stepper motors when the correct number of steps are done. The first chip's three timers are programmed in mode 3 which

is a square wave generator mode. Each of the 16 bit timers are used for a separate axis (X,Y or Z). The second chip's timers are used in the mode \emptyset , that is, interrupt on terminal count mode. The data corresponding to the number of steps to be taken in each direction is programmed into each of the three 16 bit counters.

The principle of operation is described as follows :

When it is required to move the tool from (X_1, Y_1, Z_1) to (X_2, Y_2, Z_2) at a particular feed rate F , the component rates at each of the X,Y,Z directions are different depending upon the values of (x_2-x_1) , (y_2-y_1) and (z_2-z_1) and F . These velocity components are calculated and accordingly the rate generators (i.e., the timers 1,2 and 3) are programmed to these velocities as accurately as possible. Any inaccuracy in calculating the velocities should not offset the end arrival point. For this, the steps in each direction are counted and when all the steps in one direction are done, the pulses to that stepper motor are blocked by the output of the corresponding counter 1,2 or 3. To get this 3-D linear interpolation practically accurate, it is often necessary to break the long straight line into small segments and programming the counters for these segments. This way the tool travel path is kept almost linear.

The block diagram for the experimental set-up is shown in Fig. 2.1. The detailed schematic for the timer interface is shown in Fig. 2.2.

To generate the various auxiliary function signals and to read the various manual switches the 8255A Programmable Peripheral Interface (PPI) [4] chip is used. Each chip consists of three eight-bit ports which are software programmable to be configured as inputs or outputs or bidirectional ports separately. For the purpose of demonstration, simple LED indicators have been used to show the levels of the output port's signals which correspond to the auxiliary functions. Also the direction signals for the stepper motors are output through the 8255A ports. The 8255A interfaces are shown in Fig. 2.3.

We shall discuss the design and schematic of the drive system and interfaces in detail in the next section.

2.2 Drive System and Interfaces

The drive system for each axis consists of a stepper motor, a power driver and a sequence generator. The sequence generator accepts the rate pulses from the 8253 timer and the direction information from one of the ports of the 8255A PIO interface. The stepper motor driver is shown in Fig. 2.4. The sequence generator is shown in detail in Fig. 2.5.

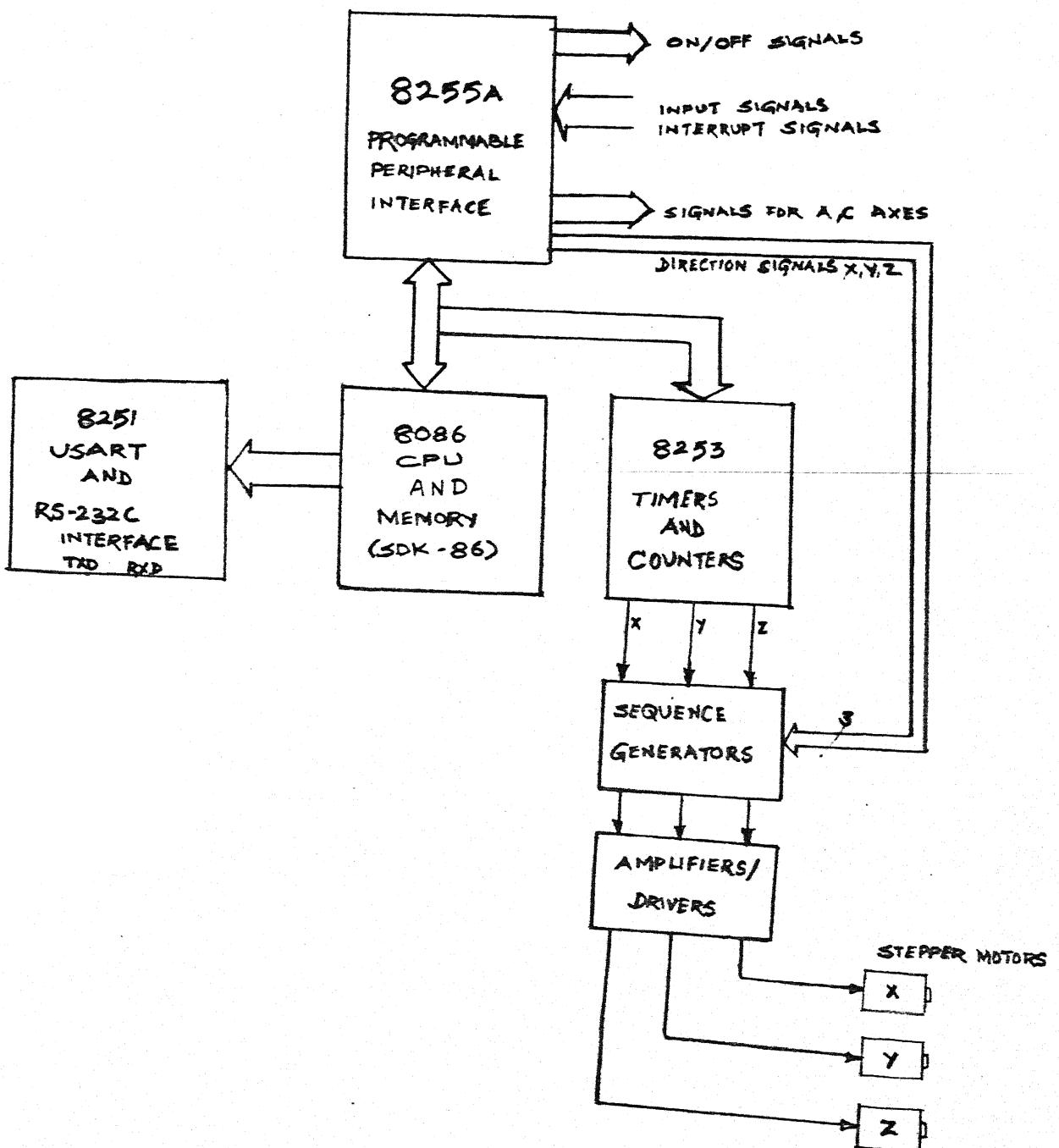


FIG 2.1 BLOCK SCHEMATIC FOR EXPERIMENTAL SETUP

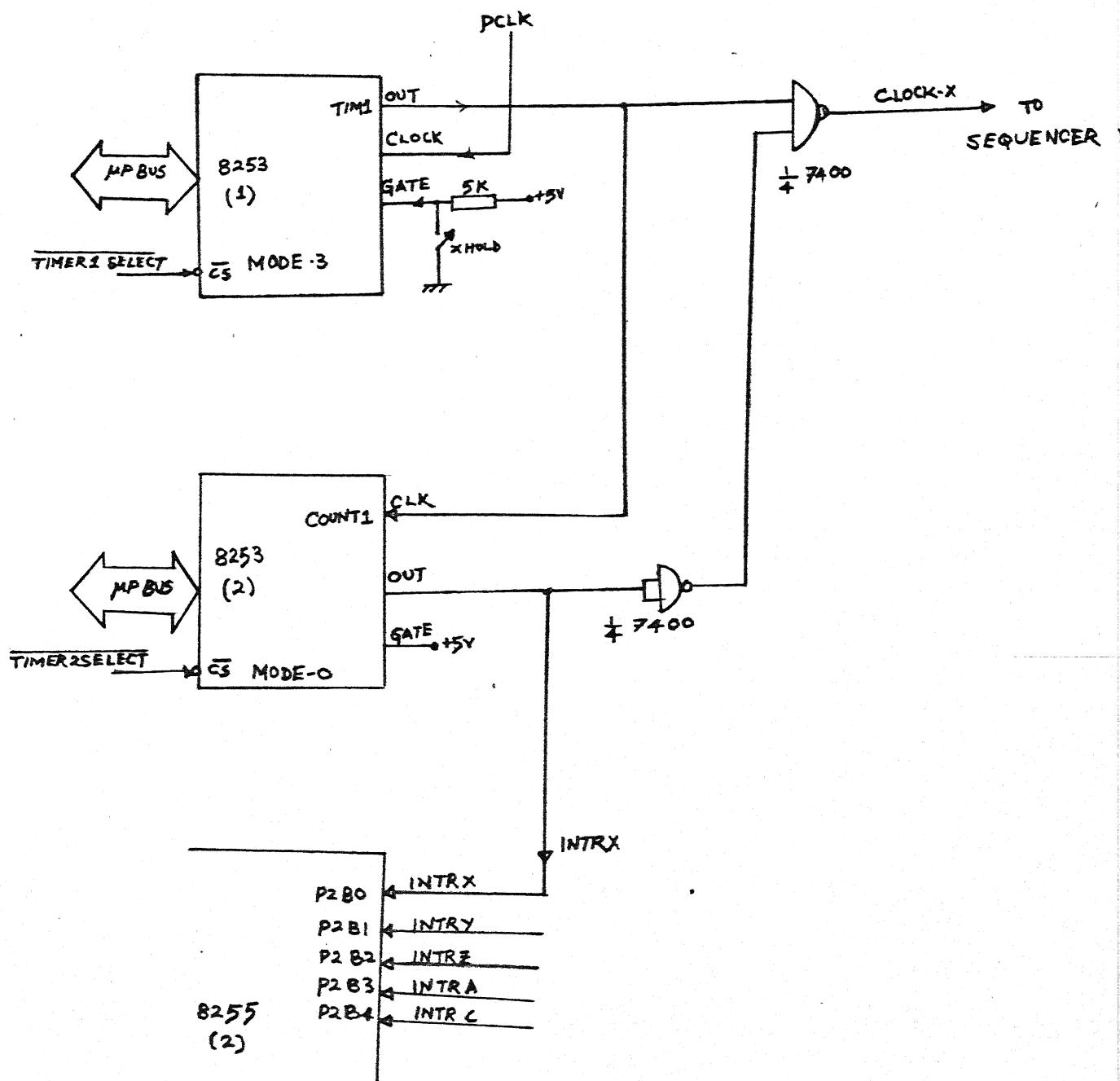


Fig 2.2.

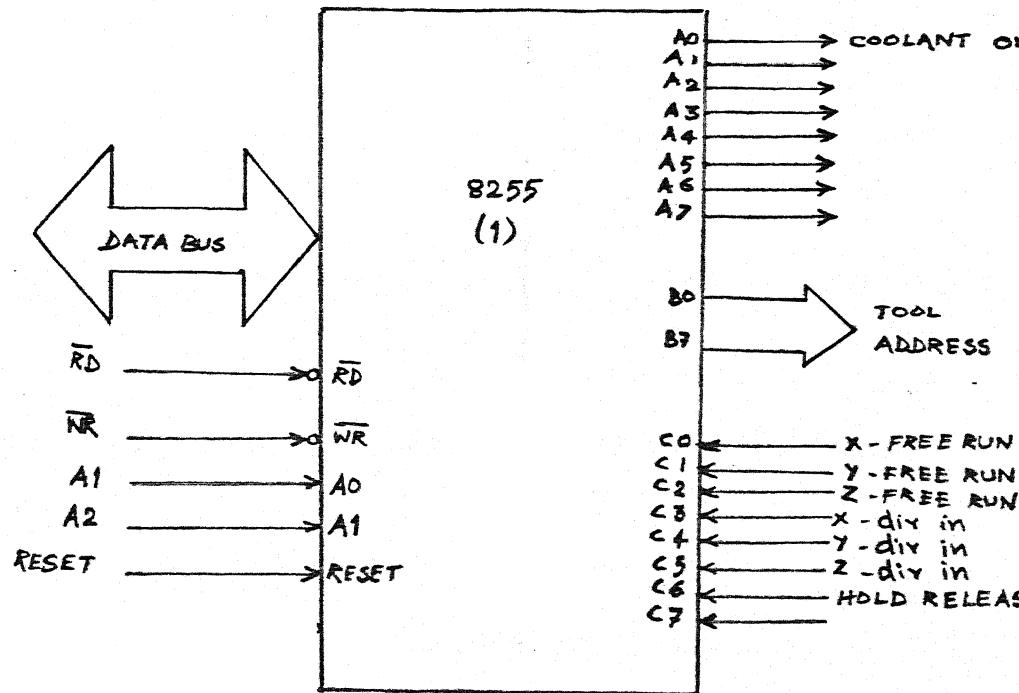
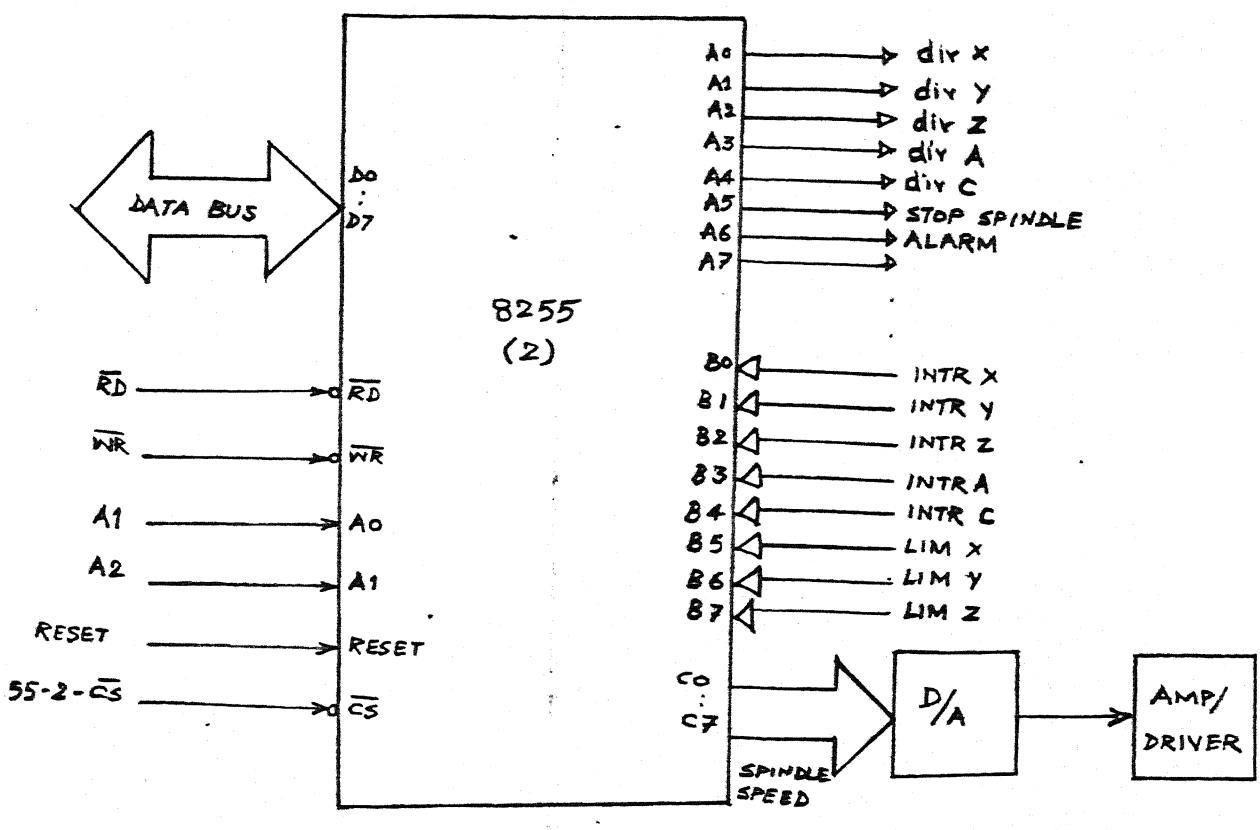


Fig 2.3. INPUT OUTPUT PORTS SCHEMATIC

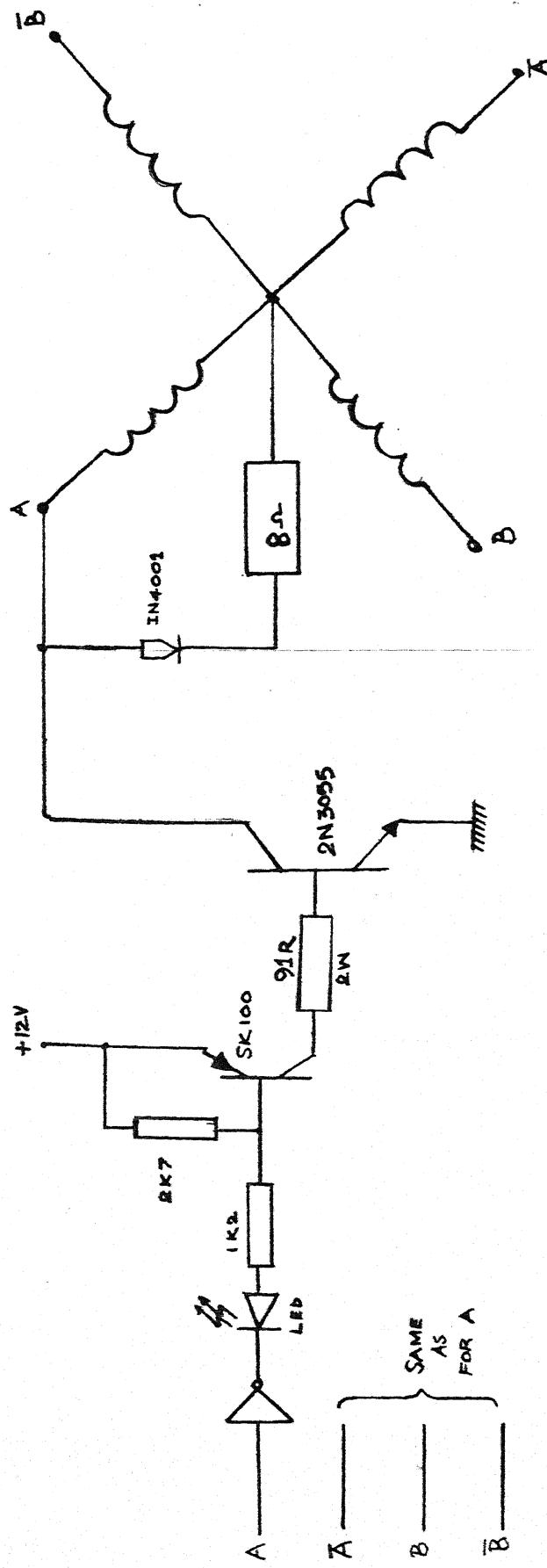


Fig 2.4 STEPPER MOTOR DRIVER

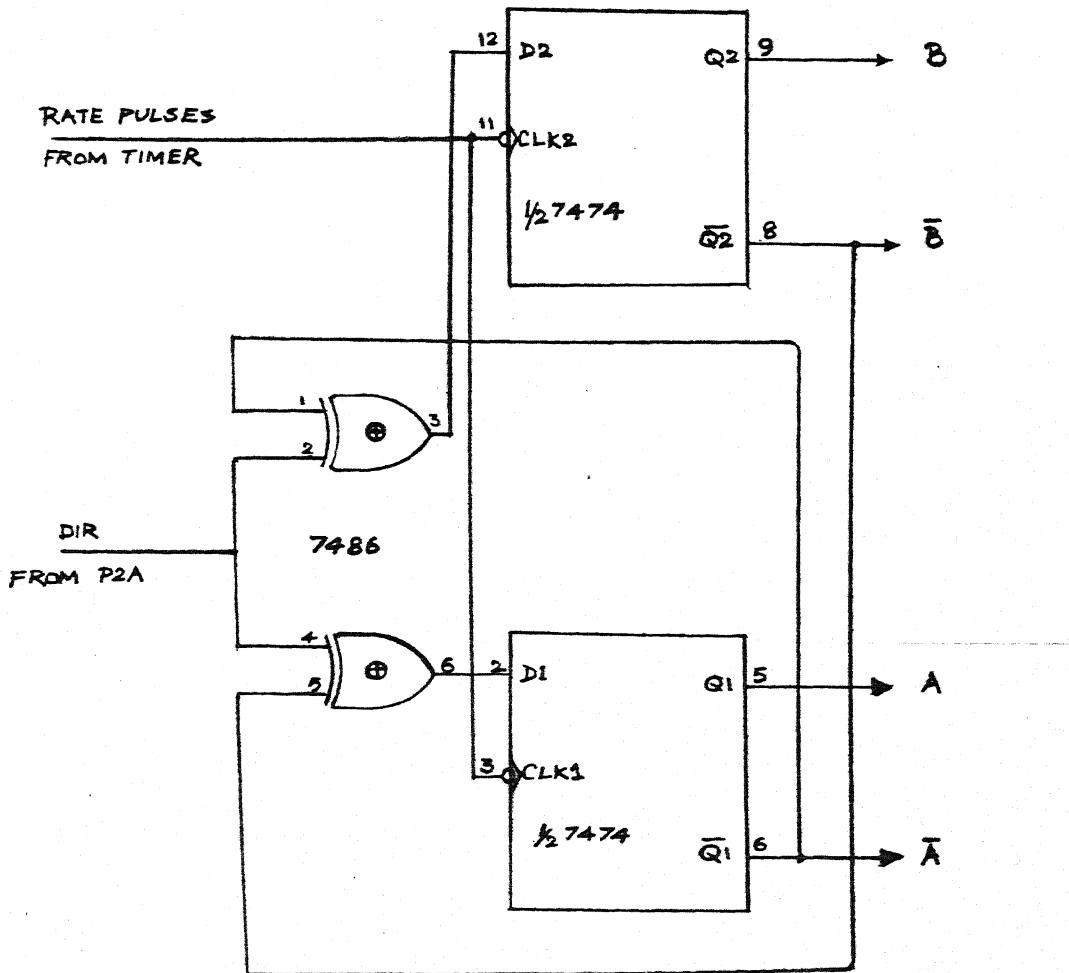


Fig. 2.5. SEQUENCE GENERATOR

The sequence generator consists of two D type flip-flops and two exclusive 'Or' gates as shown in Fig. 2.5. The sequence of excitation for forward (dir = 1) and reverse (dir = 0) is shown in Table 2.1.

Table 2.1

Direction	Dir	Sequence for AB			
Forward	1	00	01	11	10
Reverse	0	00	10	11	01

The sequence generator changes states at the rising edge of the clock pulses coming from the 8253 timer. The 'dir' signal is coming from Port A of 8255A chip No.2. The outputs A and B are inverted and available as \bar{A} and \bar{B} to be amplified by the driver amplifier shown in Fig. 2.4.

The driver amplifier should be capable of handling the maximum load current of the stepper motor.

The power transistor 2N3055 was selected to drive the motor coils which draw a maximum current of about one ampere. To provide the necessary drive current at the base of the power transistor which is around 15m Amp, one SK 100 transistor stage is provided. The SK 100 transistor is driven by the 7406 open

collector inverter. So when the input to the inverter is high, the SK 100 transistor enters saturation. This in turn switches the power transistor ON causing current to flow in the appropriate coil. Due to the high inductance of the coils when switching takes place the current through them cannot vary as fast as the voltage. Hence the transistors may get damaged due to the excessive currents. To overcome this problem, it is mandatory that we provide some alternate path for the currents to flow. Usually this path consists of a diode in series with a dissipating resistor, connected as shown in the circuit diagram in Fig. 2.4.

Since the experimental set-up has a small two axis mechanical table, the motor selected is of 2 kg-cm torque with 200 steps per sec speed and 200 steps per revolution. The stepper motor is used in this system because its positional accuracy is good and no incremental error is involved. The disadvantage is that when a step is applied, the shaft oscillates about the final position before settling down. This problem can be ignored because when pulses are applied in rapid succession, the oscillations do not show up. Also the load tends to dampen the oscillations [6].

The timer/counter interfaces and Input/Output interfaces were discussed in the previous section.

2.3 Plotter Version

Because of mechanical problems resulting from poor alignment of the leadscrews the mechanical table with two axes exhibited considerable amount of friction, it was decided to demonstrate the software with the help of a plotter. The plotter to be used has a RS232-C interface through which our microcomputer can send commands for movement of the pen in X and Y axes. Though the plotter has inbuilt linear interpolator and circular interpolator, to simulate the stepper motor version, use is made only of the incremental commands of the plotter. The command relevant for incremental motion is 'T' or 'D' followed by several ASCII characters as given in the Table 2.2. Use is made only of the +X, -X, +Y, -Y direction movements only. Tool movement in Z direction is restricted only to up/down positions and simulated in this set up as the pen up/down positions.

A second version closely approximating an actual NC system can be implemented using two output ports and two Digital to Analog Converters (DAC). The outputs from these two DAC's can be fed into the X,Y amplifiers of the Servogor plotter which has a feedback loop with the well known potentiometric principle. Use can be made of the DAC 30 (12 bit) chip.

Coding of incremental bytes

	e_{size}	e_{size}	direction						
			↓ 0	← 2	↑ 4	→ 6			
00	00	01		02	03	04	05	06	07
	8	0	SP	0	@	P			
01	9	1	!	1	A	Q			
02	10	2	"	2	B	R			
03	11	3	#	3	C	S			
04	12	4	\$	4	D	T			
05	13	5	%	5	E	U			
06	14	6	&	6	F	V			
07	15	7	,	7	G	W			
08	8	0	(8	H	X			
09	9	1)	9	I	Y			
10	10	2	*	:	J	Z			
11	11	3	+	;	K	[
12	12	4	,	<	L	\			
13	13	5	-	=	M]			
14	14	6	.	>	N	*			
15	15	7	/	?	O	←			
			↓ 1	↑ 3	→ 5	← 7			
			direction						

Table 2.2

Since the program is highly modular the 'MOVE' subroutine only needs to be modified to suit a particular drive type. The original software was modified to suit the plotter version and this shows the flexibility of the system.

2.4 Design Considerations

We have already discussed the considerations which led to the selection of the 16 bit microprocessor intel 8086. The stepper motor drive system was selected because of the non-requirement of feedback since it has no positioning error. The motor has a torque capacity of 2 kg-cm which suffices for our application, i.e., driving the two axis, small milling machine table.

The future modifications and expansion were taken into account while designing the software. The software was made flexible such that it needs only small modifications to suit a new drive system. So the drive system dependant part of the program was to be put into one subroutine so that only that subroutine needs to be modified to suit the change in the drive system configuration. If need arises the whole software can be easily transferred to another type of microprocessor system, say, Zilog 80, because the program was written in PLM-86 language. The selection of PLM language itself was based on the fact that most microprocessor development systems have the PLM compiler.

CHAPTER 3

SOFTWARE DEVELOPMENT

3.1 G-Codes

The concept of the numerical control is that the NC machine is provided with the displacement information by way of numbers [2,3]. But no machine slide can be moved by numerical values alone. There must be some way of telling the NC machine the relevance of each numerical data. This is done by sending an alphabetical letter preceding each numerical information. The first important matter is the symbols for the directions of the axes. Then the information like spindle speed, tool number, feed rate number, miscellaneous functions, preparatory functions etc., are to be identified with a letter called 'address'. The relationships between the letters and machine functions are given in Table 3.1. In addition to the letters there are the decimal numbers and the two signs '+' and '-', to represent the numerical data. Some special symbols and control symbols are required for building up the program. They are listed in Table 3.2. These conventions are from EIA standards [7].

The preparatory function 'G' specifies additional information to the coordinate dimensions and the type of operation

Table 3.1

Symbol	Meaning		
A	Rotation about X axis		
B	Rotation about Y axis		
C	Rotation about Z axis		
F	Feed number		
G	Preparatory function		
I	Interpolation parameter or thread pitch parallel to X axis		
J	" " Y axis		
K	" " Z axis		
M	Miscellaneous function		
N	Sequence number		
S	Spindle speed function		
T	Tool function		
X	Movement in the direction of X axis		
Y	" " Y axis		
Z	" " Z axis		

Table 3.2

Special symbols and their meaning

Symbol	Meaning
%	Start of program, also rewind stop
;	Block delimiter
LF	End of sentence
HT	Horizontal tabulator
CR	Carriage return
SP	Space
/	Sentence suppression (Block deleter)
DEL	Character deleter
+	Plus
-	Minus

to be done. The preparatory function thus forms part of the dimensioning. The G code has two digits. The meaning of important G-codes are indicated in the Appendix I.

In addition to the preparatory functions, there are auxiliary functions represented by the address 'M' followed by a two digit code. An auxiliary function is a function of an NC machine other than the control of coordinates of a workpiece or tool. It includes functions such as spindle stop, coolant on, coolant off, clamp, unclamp etc. These are called miscellaneous functions and they are explained in detail in Appendix I.

3.2 Program Description

The entire software is written and debugged in PLM high level language. Because of the modular programming features of PLM, the program consists of relevant modules performing a specific operation, making the program readable.

The flow of the program is as given in the flowchart 1 of the Appendix II. The program listing, alongwith cross reference listing, link map and load map is given in the Appendix III. We shall now discuss the program in detail.

Main Program

On system reset, the program first initializes the various interfaces used in the system. Then the buffers used for

storing the G-code sequence, co-ordinates and other scratch data are initialized.

Then the program control transfers to the subroutine which in turn reads in the G-code sequence in free format, typed in by the programmer through the CRT. After the typing is over, the stored sequence of G-code is displayed for verification. The data entry can be through the tape reader also.

Then the G-code instructions are executed one by one, after receiving a go-ahead signal through CRT. The control branches to any one of the G-code subroutines based on the value of G-function of the current block of code.

In the middle of the program the program may wait for some operator response after displaying some message like requesting change of tool etc. The machine can be stopped in the middle by emergency halt switch. After executing all the blocks, i.e., after encountering an end of file character in the input data, the program asks for instructions from the operator whether another part has to be machined or a new part program to be accepted.

Description of Utility Subroutines

'INITIAL 8251' and 'CHAR\$RDY' are procedures used to set the 8251A in asynchronous mode and to find the status of the character buffer of the 8251A, respectively. 'OUT\$CHAR'

'GET\$CHAR' outputs a character to the monitor and inputs a character from the keyboard respectively. 'OUT\$BLANK' outputs a blank or space and 'OUT\$CRLF' outputs a carriage return and line feed.

The procedure 'OUT\$STRING' is frequency used to display error messages and other interactive instructions in the CRT monitor. This procedure uses a pointer to the message data and keeps on outputting the character pointed to, by the pointer, simultaneously incrementing the pointer, till the data pointed to is 0. This module uses 'OUT\$CHAR' and 'OUT\$SRLF' procedures.

Function CHK\$VALID returns true if the character is an address for a specific function, i.e., N,G,X,Y,Z,A,C,I,J,S,F, T or M, and returns false if it is not a valid function. Procedure 'GET\$DATA' stores one block of G-code sequence into the buffer 'BUFFER', which is pointed to by 'INDEX'. The input to this procedure is 'FILE\$DATA' with a pointer 'FILE\$INDEX'.

Procedure 'INITIAL\$DATA' initializes the buffers for the past and new values of the codes and coordinates. Procedure 'STORE\$FILE' reads characters from the CRT, with facilities for line editing, and stores them in the 'FILE\$DATA' array. Each of the G-code blocks is separated by a semicolon ';', and the entire file is ended by an ESCAPE character.

The procedure GET\$NEWS\$CODE gets the new values of codes into the respective arrays through the use of procedures 'CODE\$3', 'CODE\$2' and 'CODE\$COORD'. If a character other than the standard codes is encountered, a warning message is given and the processing continues. The most important procedure in the software is the 'ACTION' procedure, which takes appropriate actions according to the G and M functions. This is also the only part of program which needs to be modified to suit another drive system. In the stepper motor version, the action procedure programs the counters and timers of the X,Y,Z,A,C axes and also the direction signals for them. Various auxiliary functions like spindle speed selection, coolant on coolant off, tool changing, clamping etc., are also looked after in this procedure.

Whereas, in the plotter version, instead of the programming of the counters and timers, various characters as required by the plotter (Table 2.2 lists them) are output to the plotter to effect the pen movement in X and Y axes. In the second variation of the plotter version, the X and Y voltages can be given to the plotter instead of the instructions through the plotter's RS 232-C interface. Other functions are programmed as for the stepper motor version.

3.3 Interface to Computer (Software)

The microprocessor based NC machine can communicate with a mainframe computer to receive the G-code sequence directly from the computer. The same software except for some minor modifications can be used to interact with the computer. In that case the CRT terminal will be replaced by the RS232-C port of the computer. The main modifications to be done are as follow :

Firstly the interactive part program entry is to be removed. Also we expect the computer to give error free final version of the G-code sequence. So the checking of the characters as they come through the serial link is not needed. The part of the program which displays the final version of the G-code sequences can be removed. Only the error messages and warning messages, are to be sent to the computer. Functions like tool changing, clamping and unclamping should be automated. Tool number can be output through a port which can be used by the automatic turret to select the specified tool. The workpiece can be clamped automatically by means of electro-magnetic or some other type of clamps. After the machine finishes the machining of the job, the NC machine sends a prompt indicating the computer that it needs instruction for machining one more piece of same part or for receiving new G-code program for a new part. The functions like hold etc.,

can be displayed by means of LED annunciations. The current statement number may also be displayed by means of seven segment LED displays.

3.4 Interface to Computer (Hardware)

The same RS23C-C port can be used for communication with the computer. The connection diagram is as in Fig. 3.1.

An additional port is needed to output the tool address, since the tool has to be changed automatically. For this port B of the 8255A (1) can be used as illustrated in the Fig. 2.2. One more port may be used to indicate the status of the NC machine, viz., Hold, temporary hold, dwell or stop.

3.5 Linear and Circular Interpolation Algorithms

Linear Interpolation : The software DDA algorithm described in [12] is implemented for the linear interpolation. The digital differential analyzer (DDA) method is an interpolation procedure which was developed for use in hardware interpolation. This method requires successive additions in order to create interpolated points and is therefore ideally suited for assembly language simulation. The rate at which the pulses to each axis are sent is controlled by a programmable frequency source, whose output is connected to the interrupt pin, thereby controlling the feed rate to the required level. The algorithm operates as follows, and also as expressed by the flow chart no.3, in Appendix II.

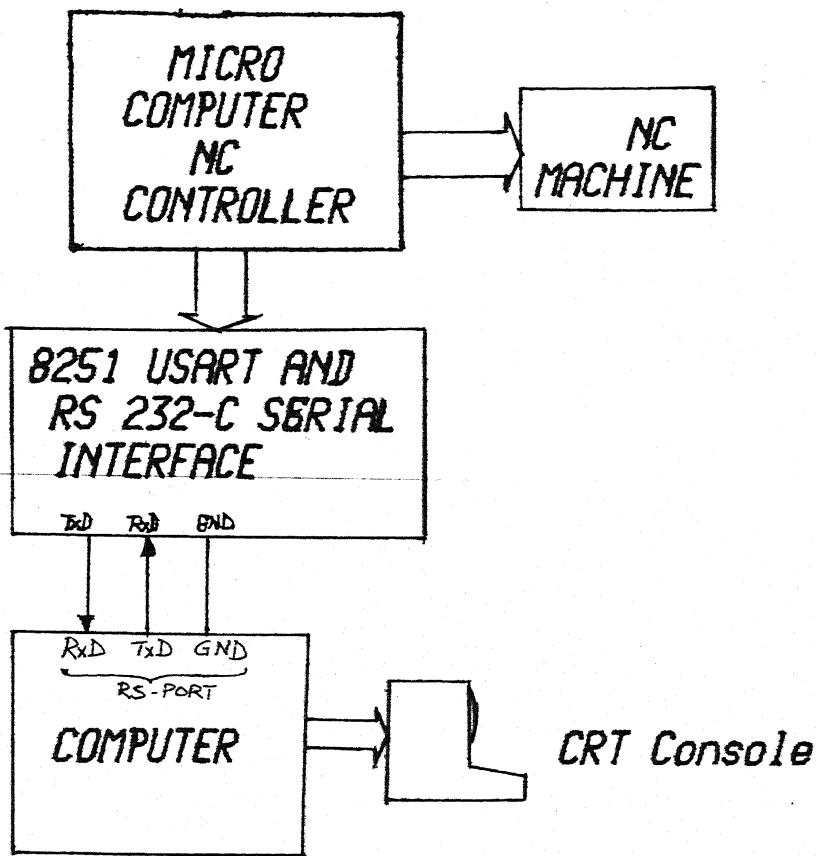


Fig.3.1. Interface to Computer

First, the distances to be moved in X and Y directions (positive or negative) are calculated. The signs of X and Y directions are determined and output. The distances in Basic Length Units (BLU's) are added to give M, which is the total number of pulses to be output in both the directions together. A function $f(x,y)$ is calculated and updated after each pulse is output. This function is initially zero and becomes $F+delx$ or $F+dely$ depending upon the last pulse output is in X direction or in Y direction; $delx$ is equal to $-dy$ where dy is the distance moved in y direction and $dely$ is equal to $+dx$ where dx is the number of pulses to be given to X axis motor (distance moved in BLU's). When the function f changes from negative to positive pulses are given to the Y motor and when the function f changes from positive to negative, pulses are given to the X motor. When all the required pulses are given to the motors, the interpolation ends. This method of linear interpolation is ideally suitable for implementation in assembly language in microcomputers and also for the reference pulse interpolators.

Circular Interpolation : Implementing circular interpolation in a microcomputer controlled system is not easy [8]. It must be done to a guaranteed accuracy regardless of the radius, within an allowed amount of time. Previously the circular interpolation was done in hardware [12], and, with the advent

of microprocessors the interpolation was implemented in software for want of accuracy and flexibility [9,10]. The approach can be in two distinct directions: the reference pulse interpolators [11] or the reference word interpolators [13]. The reference pulse interpolators are simple to implement and are accurate enough. But the reference word interpolators are complex if accuracy is needed. Since one segment rather than the immediate neighbour point of the curve is calculated at each iteration, the curve is generated with fewer iterations, though the iteration itself may take more processor time. Since our need is limited to a few thousand BLU's per second, (which is due to the nonavailability of faster step motors with higher torque), the first method, i.e., reference pulse interpolators is implemented in our system. A detailed study of various interpolators of the first method had been done in [11]. A simple algorithm for the second type of interpolation is described in [8]. Of the four types of reference pulse interpolators that Koren, Y [11] describes, the improved direct search method was found to be accurate and also appropriate for our system and hence it has been implemented in our system. The error involved is $1/2$ BLU maximum. The algorithm first evaluates the direction of each axis movement and the distance to be moved and the centre of the circular arc. A function D, similar to that used in linear interpolation is evaluated for three possible increments: in X direction, in Y direction and,

in X and Y direction. This function is proportional to the errors caused because of the corresponding movements. Then decision is taken as to which path is to be taken, based on the three error functions d_1 , d_2 and d_3 . Then the pulses are sent to the appropriate axes. This completes one iteration. The iterations end when the computed point passes [10] the final point. The algorithm is illustrated by means of the flow chart 4 of the appendix II.

CHAPTER 4

TEST EXAMPLES

4.1 Example No.1 (Point-to-point positioning)

This example illustrates how the NC system can be used as a point-to-point positioning machine, i.e., like a drilling machine. The following G-code sequence is typed in at the CRT console.

```
N01 G00 ;  
N02 G91 X0 Y200 ;  
N03 X300 Y400 ;  
N04 X300 Y0 ;  
N05 X500 Y-400 ;  
N06 X0 Y-200 ;  
N07 X-1100 Y0 M02;
```

The first statement informs the machine that point-to-point programming mode be set, through the G-code G00. The second statement sets the machine in the incremental dimensioning mode (G91). The series of co-ordinates command the tool to move to the required points. The seventh statement implies that end of program is arrived (through the miscellaneous code M02).

The plotter output corresponding to the above set of commands is given in Fig. 4.1. One can see that the movement is such that it arrives at the end point in shortest possible time.

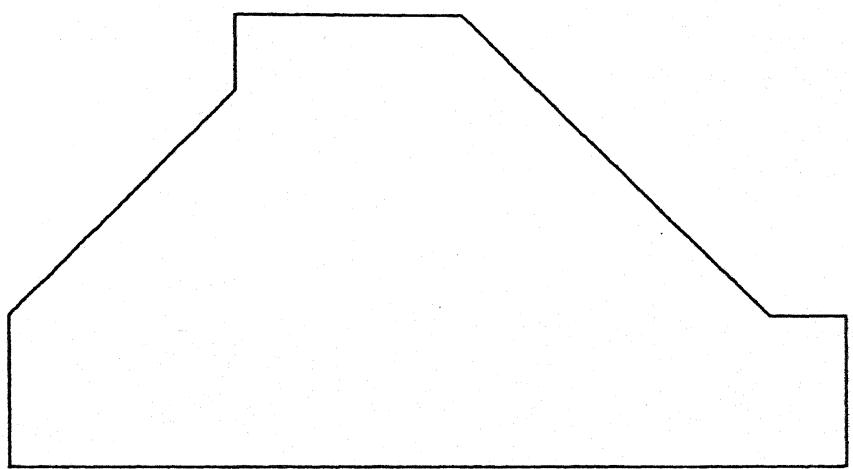


Fig. 4.1. Point-to-point positioning

4.2 Example No.2 (Linear Interpolation)

The second example illustrates the application of this NC system as a contouring milling machine with straight line cuts. The following G-code instructions are typed into the CRT console.

```
N01 G01 ;  
N02 G91 X400 Y500 Z-50 ;  
N03 X0 Y200 Z50 ;  
N04 X400 Y200 ;  
N05 X400 Y0 ;  
N06 X60 Y-400  
N07 X-200 Y0 ;  
N08 X100 Y150 ;  
N09 X-300 Y0 ;  
N10 X100 Y-150 ;  
N11 X-500 Y0 ;  
N12 M02 ;
```

The first statement informs the NC system that the movement of the tool should be in linear interpolation mode. The second line has G91 code which implies that the incremental dimensioning was chosen. Then the successive endpoints coordinates are given in the next lines. The last line has a miscellaneous function M02, which informs the machine that the end of program is arrived.

The plotter output corresponding to the above G-code sequence is given in Fig. 4.2. A step size in each direction of 0.1 mm is used in the system.

4.3 Example No.3 : (Circular Interpolation)

The final example illustrates the system as a circular interpolating contouring NC machine. The following G-code sequence is typed into the CRT console.

```
N01 G00 X400 Y500 Z50 ;
N02 G01 X0    Y200 Z50 ;
N03 X200 Y0   ;
N04 G02 X200 Y200 I200 J0 ;
N05 G02 X200 Y200 I0   J200 ;
N06 G01 X200 Y0   ;
N07 X0    Y-200 ;
N08 X800 Y0   ;
N09 M02 ;
```

The first statement positions the tool (pen) at bottom left corner of the workpiece. Statements 2 and 3 move the tool in linear interpolation mode. The fourth statement commands the machine tool to take a clockwise circular path. This moves the tool through one quadrant of the circle. The next statement moves the tool through another quadrant. Statements 6 through 8 moves the tool in linear interpolation mode. The machine stops when it encounters the program end (M02) auxiliary function.

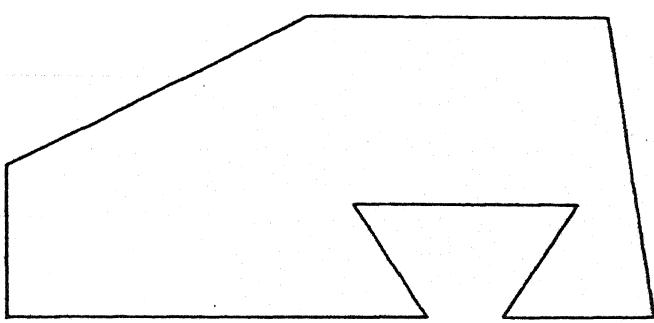


Fig. 4.2 Linear Interpolation

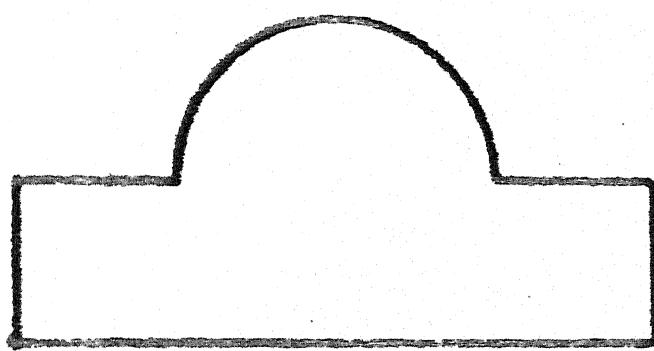


Fig. 4.3 Circular Interpolation

The plotter output corresponding to the above example is given in Fig. 4.3. It is to be noted that at a time the tool can be commanded to move through only one quadrant of a circle. The direct search method and other reference pulse circular interpolation methods have this limitation in common.

CHAPTER 5

CONCLUSIONS AND SUGGESTIONS

6

5.1 Technical Summary

The hardware and the software were tested successfully for the NC machine. The point-to-point positioning, linear interpolation and the circular interpolation algorithms are found to be suitable to implement on a reference pulse CNC machine. Because of nonavailability of a stepper motor controlled NC milling table, it was decided to simulate the machine by a plotter. Use was made only of the plotter's +X, -X, +Y, -Y incremental mode commands and this approximated a stepper motor controlled NC milling table.

The software is written in appropriate modules to suit future modifications. The whole program controlling the NC machine has been written in PLM-86 rather than in assembly language of intel 8086, to facilitate portability. So, if need arises the system can be re-modified to suit another microprocessor. Since it was not intended to drive the plotter in real-time (since the communication with the plotter is through a slow serial link), the reference pulse interpolation [11] or the reference word interpolation [13] technique was not really implemented, in the sense, that the microprocessor is not interrupted by the reference pulses at a frequency proportional to

the feed rate. This can be easily done with a programmable frequency source whose output is tied with the interrupt pin (INTR) and suitable changes in software. The interpolation routines are clustered into the subroutine MOVE, so that this subroutine can be used as the interrupt service routine. Essentially the movement in X,Y or Z should be made in synchronism with the reference pulses. A detailed study of the techniques involved is found in [11].

5.2 Suggestions for Further Work

The main theme of this project has been to design a full-fledged CNC work station. The present work is the first step towards the work station concept. The gap between the small CNC work station and large CNC centers is becoming narrower day by day [9], with miniaturisation and cost reduction in electronics. More and more facilities are included in the small work stations controlling a single NC machine. Based on the results of the present work the following suggestions are made for further work, to bring about the CNC machining center concept to practice :

- (1) An interrupt structure can be designed to implement the reference pulse interpolation, on a true multiaxis milling table.

(2) Presently the circular interpolation (G02, G03) is implemented in one plane only. The third simultaneously controlled axis can be also moved during the circular motion of the other two axes, to implement helical interpolation.

(3) An algorithm can be devised to control the three axes simultaneously using DDA method. Mayorov F.V. [12] gives insight into the DDA concepts.

(4) A feedback loop can be incorporated with the instalment of resolvers and up/down counters to drive a dc motor controlled machine, with the help of D to A converters and appropriate drive amplifiers.

(5) A floppy disk controller can be added to store the part programs. Also, more facilities can be included in the text editor.

(6) With more memory added in the microcomputer system, a high level part programming language can be implemented in the system.

The above suggestions are only a few of the many possible ideas for future work.

APPENDIX I

G-CODE CONVENTIONS

Address Functions

Character	Function
A	Angular dimension around X-axis
B	Angular dimension around Y-axis
C	Angular dimension around Z-axis
D	Specifies tool offset and cutter compensation offset number
F	Specifies feed rate
G	Specifies operation mode (linear, circular etc.,)
H	Auxiliary function (ON/OFF controls)
I	Interpolation parameter along X-axis
J	" " Y-axis
K	" " Z-axis
L	Subprogram number
M	Auxiliary function (ON/OFF controls)
N	Sequence number
S	Specifies revolution speed of main spindle
T	Specifies a tool number
X	Basic co-ordinate axis (X-axis)
Y	" " (Y-axis)
Z	" " (Z-axis)

 Preparatory Functions (G-functions)

Code	Function
G00	Point-to-point, positioning at max speed
G01	Linear interpolation at specified feed rate
G02	Circular interpolation (clockwise)
G03	Circular interpolation (counter clockwise)
G04	Dwell (for a specified duration-X seconds)
G09	In-position check
G28	Automatic return to zero
G29	Automatic return to zero through a specified point
G40	Cutter compensation cancel
G41	Cutter compensation to the left-side of tool path
G42	Cutter compensation to the right-side of tool path
G43	Tool axis offset (+ offset)
G44	Tool axis offset (- offset)
G53	Programming in basic machine co-ordinate system
G54	Selection of work co-ordinate system 1
G55	" 2
G60	In-position check mode
G63	Trapping mode
G64	Cutting mode
G90	Absolute input mode
G91	Incremental input mode
G92	Setting up new work co-ordinate system

G-code Format used in this system

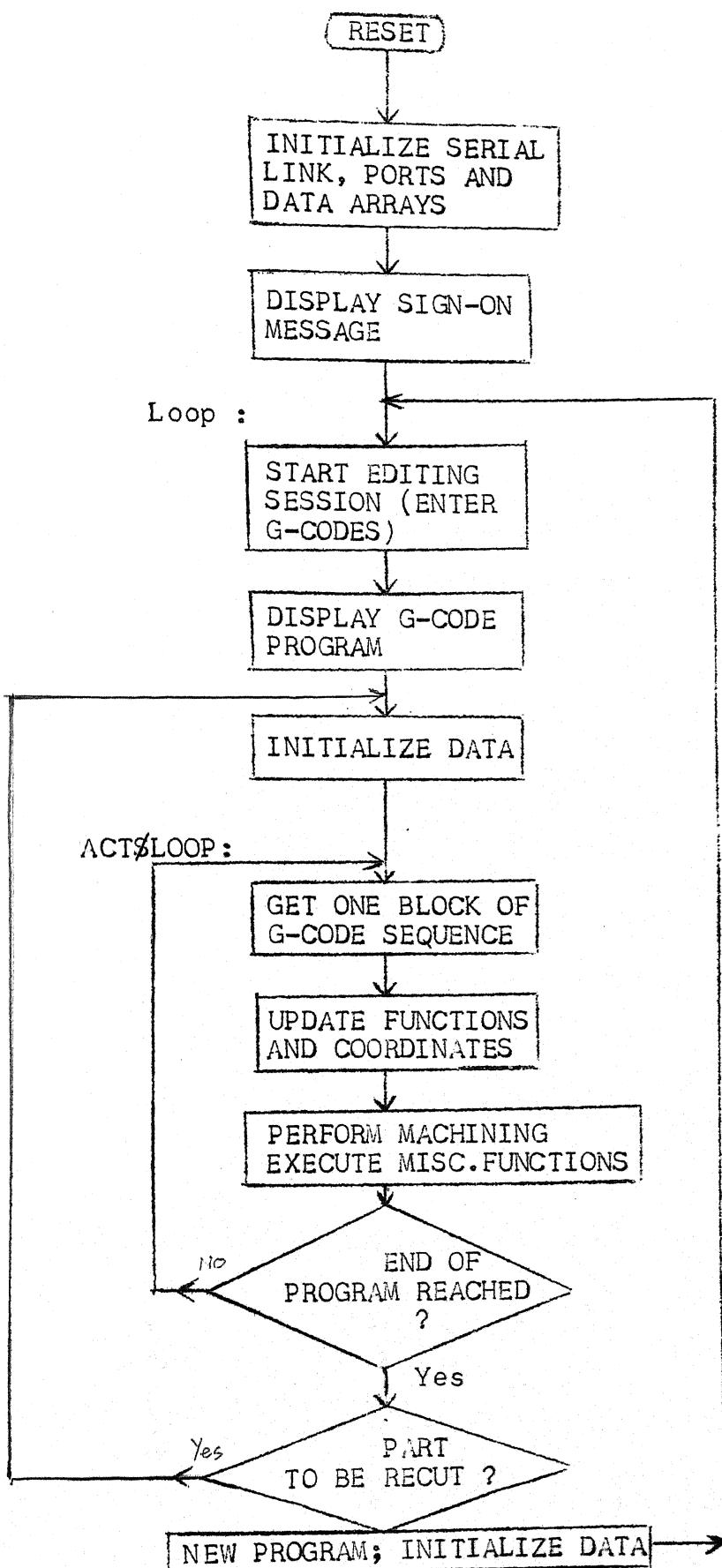
The user should type in the G-code blocks each separated by a semicolon (';'). Any blanks, linefeed, carriagereturns and illegal characters are ignored and hence not stored. The user ends editing by pressing escape <ESC> key.

Within a block, user can type in the addresses and corresponding data in any order. The only restriction is that, an address function should be followed by digits only, whose length should not exceed 5 for co-ordinates, 3 for feedrate, spindle-speed functions and 2 for other valid functions.

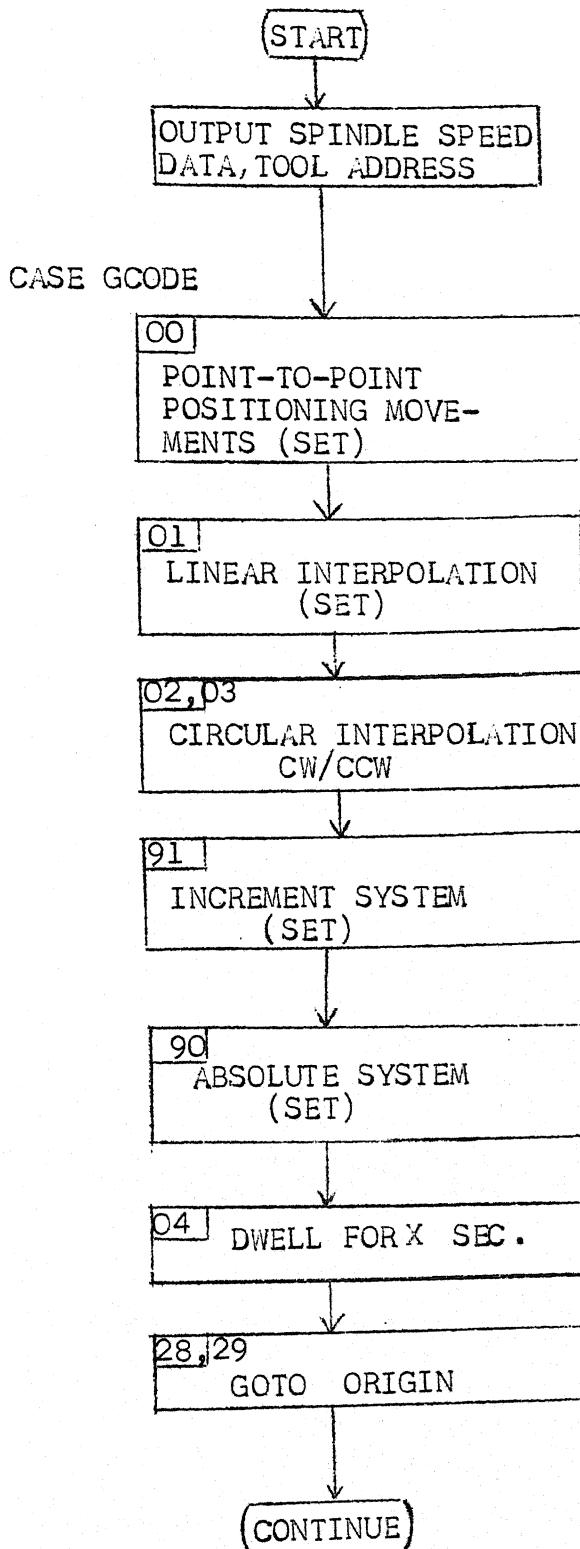
This free format is to facilitate easy entry of the co-ordinates, functions and codes.

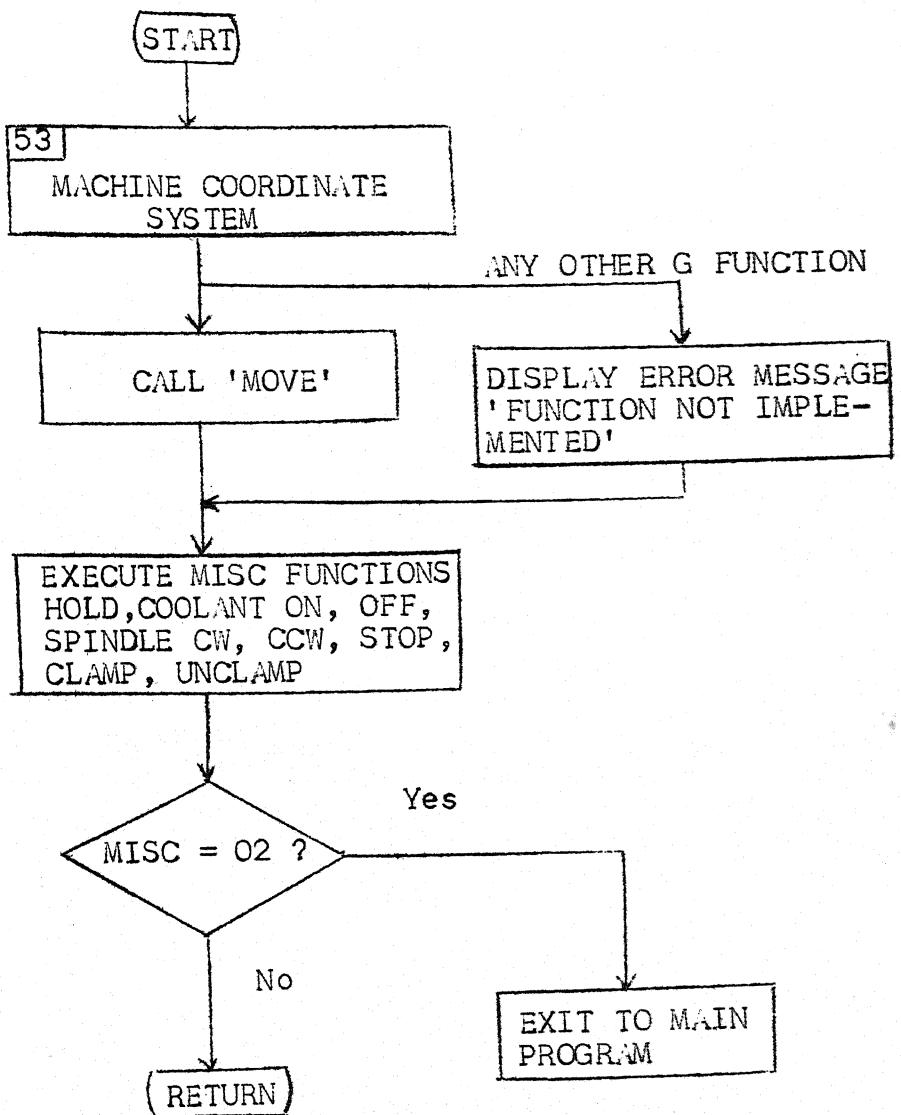
MISCELLANEOUS FUNCTIONS

Code	Function
M00	Program stop (Hold)
M01	Optional (planned) stop
M02	End of program
M03	Spindle clockwise
M04	Spindle Counter Clockwise
M05	Spindle OFF
M06	Tool change
M07	Coolant No.2 ON
M08	Coolant No.1 ON
M09	Coolant OFF
M10	Clamp
M11	Unclamp
M13	Spindle CW and Coolant ON
M14	Spindle CCW and Coolant ON
M30	End of Tape
M31-99	Optional and unassigned



Flow Chart 1 MAIN PROGRAM

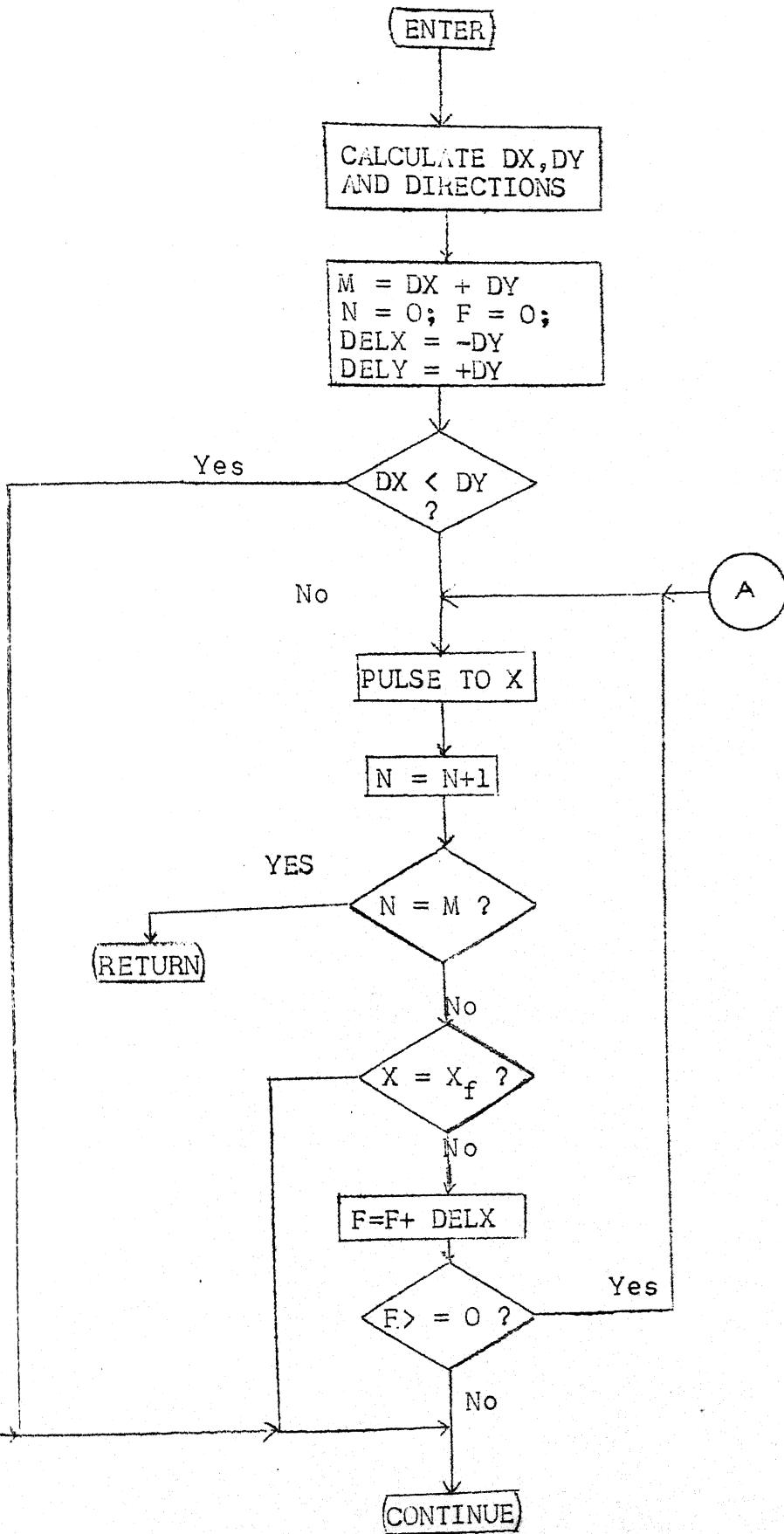


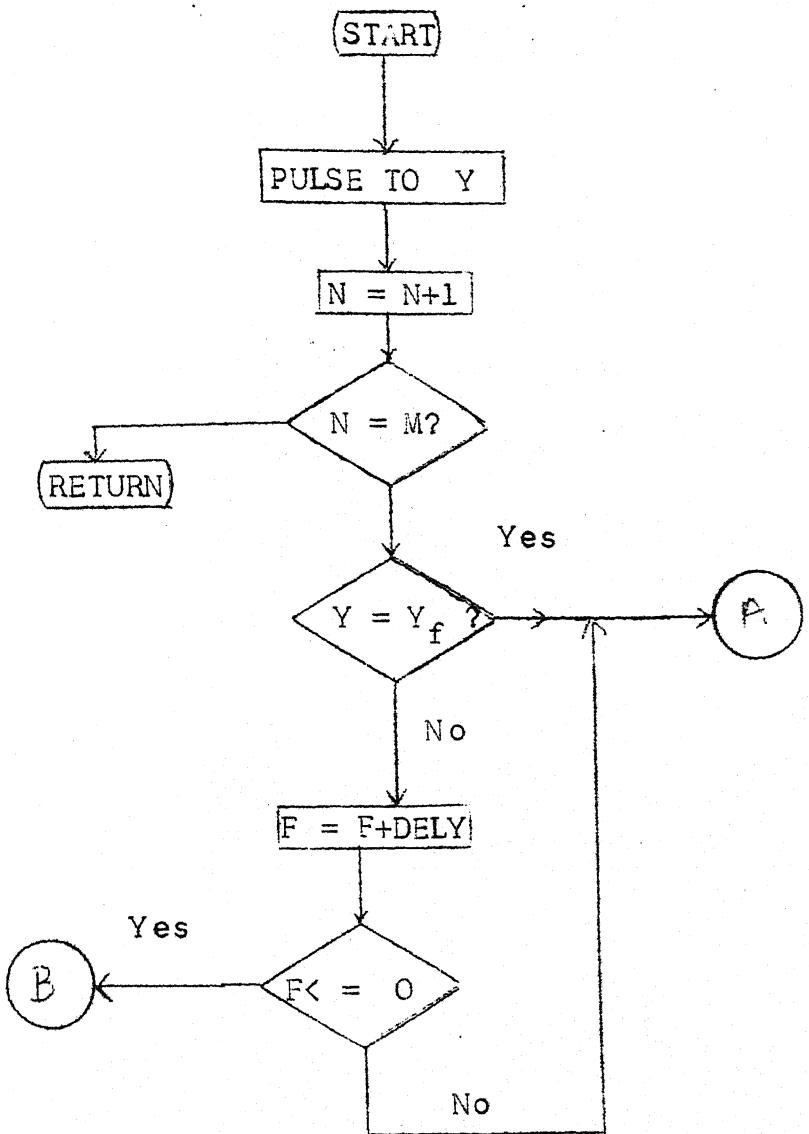


Flow Chart 2 PROCEDURE 'ACTION'

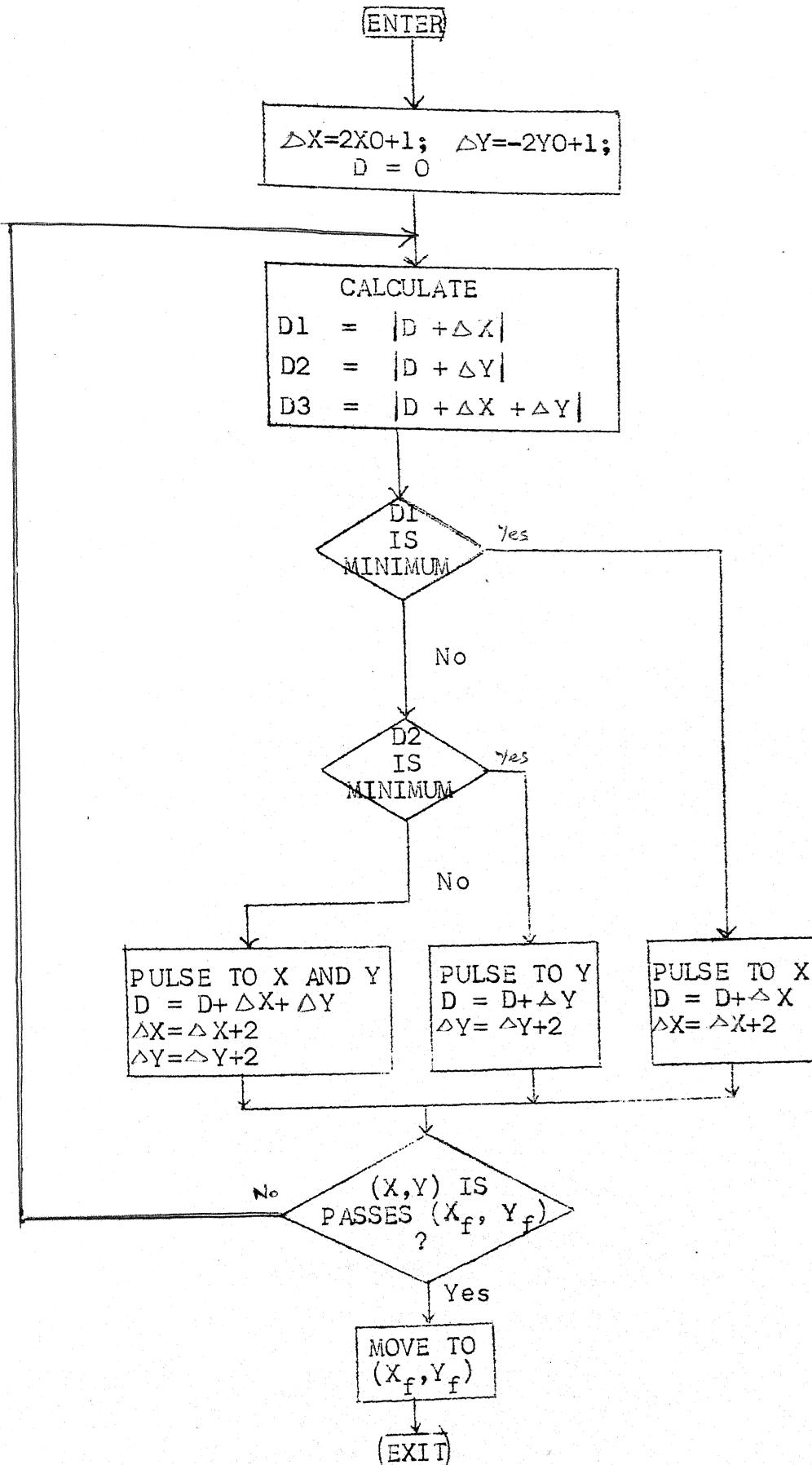
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Flow Chart 3 LINEAR INTERPOLATION ALGORITHM



III PL/M-86 V2.0 COMPILE OF MODULE NCM
MODULE PLACED IN THESIS.OBJ
INVOKED BY: :F2:PLM86.86 THESIS.PLM

```
$TITLE ('NC M/C CONTROLLER')
$LIST
$XREF
$PAGELength(50)
$PageWidth(70)
```

```
NCM: DO;
/*GLOBAL DATA DECLARATIONS*/
1 DECLARE INT$VECTOR(5) POINTER;
1 DECLARE CR LITERALLY 'ODH',
1 LF LITERALLY '0AH';
1 DECLARE
1     SIGN$ON(*) BYTE DATA (CR,LF,'NC Machine Controller
1 - -Plotter version',0),
1     ABORT(*) BYTE DATA ('^Z',CR,LF,'Run aborted',0),
1     ERR1(*) BYTE DATA('Function not implemented',0),
1     ERR2(*) BYTE DATA('Illegal character found',0);
1     DECLARE TRUE LITERALLY 'OFFH',
1         FALSE LITERALLY '000H',
1         MESS1(*) BYTE DATA ('ENTER THE G-CODE SEQUENCE WITH EA
1 - -CH BLOCK SEPARATED',0),
1         MESS2(*) BYTE DATA ('BY A SEMICOLON ; AND TO END EDITI
1 - -NG, PRESS <ESC> KEY',0),
1         MESS3(*) BYTE DATA(CR,LF,'ILLEGAL CHARACTER ENTERED; FO
1 - -R EXIT PRESS <ESC>',CR,
1             LF,0),
1         MESS4(*) BYTE DATA (CR,LF,'TYPE N TO START A NEW PROGR
1 - -AM, C TO MACHINE AGAIN',0);

1     DECLARE ERR5(*) BYTE DATA ('Unexpected character found',
1 - 0),
1         WARN(*) BYTE DATA ('WARNING: Character ignored',
1 - 0);

1     DECLARE VALID$FN(*) BYTE DATA ('NGXYZACSFMTIJ'); /*VALID
1 - FUNCTIONS/ ADDRESS*/
1     DECLARE DIGIT(*) BYTE DATA('0123456789');
1     DECLARE (I,J,K,L,M,N,II) BYTE,
1             (FL,CHAR) BYTE;
1     DECLARE FILE$INDEX WORD;
```

```
1      DECLARE FILE$DATA (1000) BYTE;
?
1      DECLARE /*Port numbers declarations*/
- PORT*/
- DATA$8251 LITERALLY `OFFF2H`, /*8251 STATUS
- DRT*/
- RESET$8251 LITERALLY `065H`, /*8251 RESET C
- OMMAND*/
- MODE$8251 LITERALLY `0CFH`, /*8251 ASYNC MO
- DE SET COMMAND*/
- CMND$8251 LITERALLY `025H`, /*ENABLE TX, RX*/
-
- DS$RDY LITERALLY `080H`, /*DSR READY MASK*/
- RX$RDY LITERALLY `02H`, /*RX READY MASK*/
- TX$RDY LITERALLY `01H`; /*TX READY MASK*/
?
1      DECLARE /*ASCII BYTE VALUES -CONST DECLARATIONS*/
- BLANK LITERALLY `20H`,
- BKSPCE LITERALLY `08H`,
- EOB LITERALLY `3BH`,
- SCRNBBLNK LITERALLY `0CH`,
- DELETE LITERALLY `010H`;
?
1      DECLARE /*BUFFERS DECLARATIONS*/
- CODE$PAST(13) INTEGER,
- CODE$NOW(13) INTEGER,
- BUFFER(128) BYTE,
- T(5) INTEGER INITIAL (0,0,0,0,0);
?
1      DECLARE INDEX BYTE;
?
1      DECLARE TEMP INTEGER;
?
1      DECLARE /*BOOTING OPCODE STORE DECLARATIONS*/
- START$ADDR LITERALLY `0000H`,
- BOOT1(*) BYTE AT (OFFFF0H) DATA (0EAH), /*L
- ONG JUMP OPCODE*/
- BOOT2(*) WORD AT (OFFFF1H) DATA (START$ADD
-R), /*OFFSET ADDRESS*/
- BOOT3(*) WORD AT (OFFFF3H) DATA (OFFOOH); /*S
- SEGMENT ADDRESS*/
?
1      DECLARE P2ABUF BYTE,
- P2BBUF BYTE,
- P2CBUF BYTE;
?
1      DECLARE P2A LITERALLY `OFFF8H`,
- P2B LITERALLY `OFFFAH`;
```

P2C LITERALLY '0FFFCH',
P2S LITERALLY '0FFE9H';

1 DECLARE INCREMENTAL BYTE,
LINEAR BYTE,
CIRCULAR BYTE,
CWISE BYTE;

/* FOR INITPORT PROCEDURE - GLOBAL VARIABLES */

1 DECLARE COOLNT LITERALLY '01H',
P1A LITERALLY '0FFF9H',
P1B LITERALLY '0FFFFBH',
P1C LITERALLY '0FFFFDH',
P1S LITERALLY '0FFFFFH';

1 DECLARE P1ABUF BYTE,
P1BBUF BYTE,
P1CBUF BYTE;

/* INITIALIZATION PROCEDURES */

1 INITPORT: PROCEDURE;
2 OUTPUT(P1S)=82H; /*P1A=OUTPUT, P1B=INPUT, P1C=OUTPUT */
2 P1ABUF=0FEH;
2 P1BBUF=00;
2 P1CBUF=00;
2 OUTPUT(P1A)=P1ABUF;
2 OUTPUT(P1C)=P1CBUF;
2 END;

1 INITIALPORTS: PROCEDURE;
2 OUTPUT(P2S)=82H;
2 P2ABUF=9FH;
2 OUTPUT(P2A)=P2ABUF;
2 P2CBUF=00H;
2 OUTPUT(P2C)=P2CBUF;
2 END;

/*LOW LEVAL PROCEDURES */

1 INITIAL\$8251: PROCEDURE;

```
39   2      OUTPUT(STAT$8251)=65; CALL TIME(50);
41   2      OUTPUT(STAT$8251)=25; CALL TIME(50);
43   2      OUTPUT(STAT$8251)=RESET$8251;
44   2      CALL TIME(50);
45   2      OUTPUT(STAT$8251)=MODE$8251;
46   2      CALL TIME(50);
47   2      OUTPUT(STAT$8251)=CMND$8251;
48   2      CALL TIME(50);
49   2      END;

50   1      CHAR$RDY: PROCEDURE BYTE;
51   2      IF (INPUT(STAT$8251) AND RX$RDY)=0 THEN RETURN FALSE;
53   2      ELSE RETURN TRUE;
54   2      END;

55   1      OUT$CHAR: PROCEDURE (CH);
56   2      DECLARE CH BYTE;
57   2      IF (CHAR$RDY) THEN CALL CHK$CTL$CHAR;
59   2      DO WHILE(INPUT(STAT$8251) AND TX$RDY)=0;
60   3      END;
61   2      OUTPUT(DATA$8251)=CH;
62   2      END;

63   1      GET$CHAR: PROCEDURE;
64   2      DO WHILE(INPUT(STAT$8251) AND RX$RDY)=0;
65   3      END;
66   2      CHAR=INPUT(DATA$8251)AND (07FH);
67   2      IF CHAR>=BLANK THEN CALL OUT$CHAR(CHAR);
69   2      IF CHAR=CR THEN CALL OUT$CRLF;
71   2      END;

72   1      OUT$CRLF: PROCEDURE;
73   2      CALL OUT$CHAR(CR);
74   2      CALL OUT$CHAR(LF);
75   2      END;

76   1      OUT$STRING: PROCEDURE(PTR);
77   2      DECLARE PTR POINTER;
78   2      DECLARE STR BASED PTR(1) BYTE ;
79   2      DECLARE IND BYTE ;
80   2      IND=0;
81   2      DO WHILE STR(IND)<>0;
82   3      CALL OUT$CHAR(STR(IND));
83   3      IND=IND+1;
84   3      END;
85   2      CALL OUT$CRLF;
```

```
86   2           END;

87   1           CHK$VALID: PROCEDURE BYTE;
                  /*INPUT TO THIS PROCEDURE IS THE GLOBAL VA-
                   -RIABLE CHAR*/
88   2           DO I=0 TO LAST(VALID$FN);
89   3           IF CHAR=VALID$FN(I)THEN RETURN TRUE;
                  /*Returns the index I, the subscript of the function in
                   -the array*/
91   3           END;
92   2           RETURN FALSE;
93   2           END;

94   1           GET$DATA: PROCEDURE;
                  /*STORES ONE BLOCK OF G-CODE SEQUENCE INTO
                   - A BUFFER*/
95   2           DECLARE IND BYTE;
96   2           IND=0;
97   2           IF (FILE$DATA(FILE$INDEX)=0) OR (FL=1) THEN GOTO E-
                   -XIT;
99    2           DO WHILE FILE$DATA(FILE$INDEX)<>(<;>);
100   3           BUFFER(IND)=FILE$DATA(FILE$INDEX);
101   3           IF FILE$DATA(FILE$INDEX)=0H THEN
                  DO; BUFFER(IND)=0; FL=1; GOTO EXT$LOOP
102   4           -; END;
103   3           IND=IND+1;
104   3           FILE$INDEX=FILE$INDEX+1;
105   3           END;
106   2           BUFFER(IND)=0;
107   2           FILE$INDEX=FILE$INDEX+1;
108   2           END;
109   2           END;

110   1           INITIAL$DATA: PROCEDURE;
                  /*Initialise CODE$PAST, CODE$NOW, FILEINDEX
                   -*/
111   2           FILE$INDEX=0;
                  /* Sets the machine in incremental, linear interpolation
                   - mode */
112   2           INCREMENTAL=TRUE;
113   2           LINEAR=TRUE;
114   2           CIRCULAR=FALSE;
115   2           CWISE=TRUE;
116   2           FL=0;
117   2           DO I=0 TO 12;
118   3           CODE$PAST(I)=0;
119   3           CODE$NOW(I)=0;
120   3           END;
```

```
124 2      CODE$NOW(1)=90; /*G FUNCTION ABSOLUTE DIMENSION */
125 2      CODENOW(9)=99; /* MISC */
126 2      END;

127 1      STORE$FILE: PROCEDURE;
128 2      DECLARE LST$BLK WORD,
129           BLK BYTE;
130 2      FILE$INDEX=0; LST$BLK=0;
131 2      BLK=0;
132 2      CALL OUT$STRING(@MESS1);
133 2      CALL OUT$STRING(@MESS2);
134 2      LOOP: CALL GET$CHAR;
135 2      IF ((CHAR>=041H) AND (CHAR<=05AH)) THEN
136 2          DO;
137 3          FILE$DATA(FILE$INDEX)=CHAR;
138 3          FILE$INDEX=FILE$INDEX+1;
139 3          END;
140 2      ELSE IF ((CHAR>=061H) AND (CHAR<=07AH)) THEN
141 2          DO;
142 3          FILE$DATA(FILE$INDEX)=CHAR-020H;
143 3          FILE$INDEX=FILE$INDEX+1;
144 3          END;
145 2      ELSE IF ((CHAR>=030H) AND (CHAR<=39H)) OR ((CHAR='+'+
146 2          '-' OR (CHAR='--')) THEN
147 3          DO;
148 3          FILE$DATA(FILE$INDEX)=CHAR;
149 3          FILE$INDEX=FILE$INDEX+1;
150 2      ELSE IF ((CHAR=BKSPCE) OR (CHAR=DELETE)) THEN
151 2          DO;
152 3          FILE$INDEX=FILE$INDEX-1;
153 3          IF FILE$INDEX=-1 THEN FILE$INDEX=0;
154 3          END;
155 2      ELSE IF (CHAR=01BH) THEN
156 2          DO; FILE$DATA(FILE$INDEX)=0; RETURN; END; /*<ESC> EN-
157 3          -COUNTERED */

158 2      ELSE IF (CHAR=BLANK) OR (CHAR=LF) OR (CHAR=CR) THEN
159 2          GOTO LOOP;
160 2      ELSE IF (CHAR=';' '/') THEN
161 2          DO;
162 3          FILE$DATA(FILE$INDEX)=CHAR;
163 3          LST$BLK=FILE$INDEX;
164 3          BLK=BLK+1;
165 3          FILE$INDEX=FILE$INDEX+1;
166 3          END;
167 3      ELSE IF (CHAR=015H) THEN /* IF CHAR=CTL U */
168 2          DO;
```

```
172   3           FILE$INDEX=LST$BLK;
173   3           CALL OUT$CRLF;
174   3           END;
175   2           ELSE
176   3               DO;
177   3                   CALL OUT$STRING(@MESS3);
178   2           END;

178   2           IF FILE$INDEX > 998 THEN DO;
179   3               DECLARE LIMITERR(*) BYTE DATA ('File limit exceeded;
180   3                   -EOF inserted.', 0);
181   3               CALL OUT$STRING(@LIMITERR);
182   3               FILE$DATA(FILE$INDEX)=0;
183   3               RETURN;
184   3           END;
185   2               GOTO LOOP;
186   2           END;

187   1           CHK$CTL$CHAR: PROCEDURE;
188   2               CHAR=INPUT(DATA$8251) AND 07FH;
189   2               IF CHAR=13H THEN /* CTL S? */;
190   3                   DO WHILE (CHAR<>11H); /* CTL Q? */;
191   3                       IF CHAR$RDY THEN
192   3                           DO;
193   4                               CHAR=INPUT(DATA$8251) AND 07FH;
194   4                               IF CHAR=1AH THEN GOTO CTLZ; /* CTL Z */;
195   4                           END;
196   3                       END; /* DO WHILE */;
197   2                           ELSE IF CHAR=1AH THEN GOTO CTLZ;
198   2           END; /* CHK$CTL$CHAR */;

202   1           ACTION: PROCEDURE;
203   2               DECLARE CODE INTEGER,
204   3                   MISC INTEGER,
205   4                   SPEED INTEGER,
206   5                   TOOL INTEGER,
207   6                   TOOLMESS(*) BYTE DATA ('Automatic tool change being
208   7                   -done', 0);

209   2           DECLAR MAXSPEED INTEGER DATA (125);

210   2           OUTINTEGER: PROCEDURE(NUMBER);
211   3               DECLARE NUMBER INTEGER;
212   3               P1CBUF=LOW(UNSIGN(NUMBER));
213   3               OUTPUT(P1C)=P1CBUF;
214   3           END;
```

```
210  2      HOLD: PROCEDURE;
211  3          REP: I=INPUT(P1B);
212  3          I=I AND (40H) ;
213  3          IF I=0 THEN GOTO REP;
214  3          END;
215  3
216  2      NOTIMPLEMENT: PROCEDURE;
217  3          CALL OUTSTRING(@ERR1);
218  3          END;
219  2      DELAY: PROCEDURE;
220  3          DECLARE N WORD;
221  3          DO N=1 TO CODENOW(2);
222  4              CALL TIME(125);
223  4          END;
224  3          CODENOW(2)=CODEPAST(2);
225  3
226  2      MOVE: PROCEDURE;
227  3          /* LOCAL VARIABLES DECLARATIONS */
228  3          DECLARE X2 LITERALLY `CODENOW(2)`,
229  3                  Y2 LITERALLY `CODENOW(3)`,
230  3                  Z2 LITERALLY `CODENOW(4)`,
231  3                  X1 LITERALLY `CODEPAST(2)`,
232  3                  Y1 LITERALLY `CODEPAST(3)`,
233  3                  Z1 LITERALLY `CODEPAST(4)`;
234  3
235  3          DECLARE DX INTEGER,
236  3                  DY INTEGER,
237  3                  DZ INTEGER;
238  3
239  3          DECLARE SIGNX BYTE,
240  3                  SIGNY BYTE,
241  3                  SIGNZ BYTE;
242  3
243  3          DECLARE XPLUS LITERALLY `50H`, /* `P1` , `E` , `0` , ` ` */;
244  3                  YPLUS LITERALLY `40H`;
245  3                  XMINUS LITERALLY `30H`;
246  3                  YMINUS LITERALLY `20H`;
247  3
248  3          DECLARE CHX BYTE ,
249  3                  CHY BYTE ,
250  3                  CHXY BYTE ;
251  3
252  3          DECLARE (M, N, F, MX, MY, DELX, DELY) INTEGER;
```

```
/* Declarations for variables used in the circular interpolation */
```

```
233 3 DECLARE (II,JJ,XC,YC,X,Y,FX,FY,LX,LY,D1,D2,D3,D) INTEGER  
-;
```

```
234 3 SIGNX=FALSE;
```

```
235 3 SIGNY=FALSE;
```

```
236 3 SIGNZ=FALSE;
```

```
237 3 IF INCREMENTAL=FALSE THEN DO;
```

```
239 4 DX=X2-X1;
```

```
240 4 DY=Y2-Y1;
```

```
241 4 DZ=Z2-Z1;
```

```
242 4 END;
```

```
243 3 ELSE DO;
```

```
244 4 DX=X2;
```

```
245 4 DY=Y2;
```

```
246 4 DZ=Z2;
```

```
247 4 END;
```

```
248 3 IF DX<0 THEN DO;
```

```
250 4 SIGNX=TRUE;
```

```
251 4 DX=-DX;
```

```
252 4 END;
```

```
253 3 IF DY<0 THEN DO;
```

```
255 4 SIGNY=TRUE;
```

```
256 4 DY=-DY;
```

```
257 4 END;
```

```
258 3 IF DZ<0 THEN DO;
```

```
260 4 SIGNZ=TRUE;
```

```
261 4 DZ=-DZ;
```

```
262 4 END;
```

```
263 3 CALL OUTCHAR('&');
```

```
264 3 IF SIGNX THEN CHX=XMINUS; ELSE CHX=XPLUS;
```

```
267 3 IF SIGNY THEN CHY=YMINUS; ELSE CHY=YPLUS;
```

```
270 3 IF SIGNZ THEN CALL OUTCHAR('H');
```

```
272 3 ELSE CALL OUTCHAR('I');
```

```
273 3 /* PEN UP OR PEN DOWN */
```

```
CALL OUTCHAR('D');
```

```
274 3 M=DX+DY;
```

```
275 3 F=0;
```

```
276 3 MX=0;
```

```
277 3     MY=0;
278 3     N=0;
279 3     IF LINEAR THEN DO;
               /*Linear Interpolation begins */

281 4     DELX=-DY;
282 4     DELY=DX;
283 4     IF (DX<>0) AND (DY<>0) THEN GOTO BOTH;
285 4     IF (DX=0) AND (DY=0) THEN GOTO DONE;
287 4     IF (DX=0) THEN CHXY=CHY; ELSE CHXY=CHX;
290 4     DO WHILE N<M;
291 5     CALL OUTCHAR(CHXY);
292 5     CALL TIME(100);
293 5     N=N+1;
294 5     END;
295 4     GOTO DONE;
296 4     BOTH: IF (DX<DY) THEN GOTO YALSO;
298 4     XALSO: CALL OUTCHAR(CHX); CALL TIME(100);
300 4     N=N+1;
301 4     MX=MX+1;
302 4     IF N=M THEN GOTO DONE;
304 4     IF MX=DX THEN GOTO YALSO;
306 4     F=F+DELX;
307 4     IF F>=0 THEN GOTO XALSO;
309 4     YALSO: CALL OUTCHAR(CHY); CALL TIME(100);
311 4     N=N+1;
312 4     MY=MY+1;
313 4     IF N=M THEN GOTO DONE;
315 4     IF MY=DY THEN GOTO XALSO;
317 4     F=F+DELY;
318 4     IF F<=0 THEN GOTO YALSO;
320 4     GOTO XALSO;
321 4     DONE: /* Interpolation ends */

               END;

322 3     ELSE IF CIRCULAR THEN
323 3     DO; /* Circular interpolation begins */
324 4     II=CODENOW(11);
325 4     JJ=CODENOW(12);
326 4     XC=X1+II;
327 4     YC=Y1+JJ;
328 4     X=X1;
329 4     Y=Y1;
330 4     FX=X2;
331 4     FY=Y2;
332 4     IF (Y>YC) THEN DELX=1; ELSE DELX=-1;
```

```
335   4      IF (X>XC) THEN DELY=-1; ELSE DELY=1;
338   4      IF (X=XC) THEN DO;
340   5          IF (Y>YC) THEN DO;
342   6              DELY=-1;
343   6              DELX=1;
344   6              END;
345   5          ELSE DO;
346   6              DELY=1;
347   6              DELX=-1;
348   6              END;
349   5          END;
350   4      IF (Y=YC) THEN DO;
352   5          IF (X>XC) THEN DO;
354   6              DELX=-1;
355   6              DELY=-1;
356   6              END;
357   5          ELSE DO;
358   6              DELX=1;
359   6              DELY=-1;
360   6          END;
361   5      END;
362   4      IF CWISE=FALSE THEN DO;
364   5          IF (Y>YC) THEN DELX=-1; ELSE DELX=1;
367   5          IF (X>XC) THEN DELY=1; ELSE DELY=-1;
370   5          IF (X=XC) THEN DO;
372   6              IF (Y>YC) THEN DO;
374   7                  DELY=-1;
375   7                  DELX=-1;
376   7                  END;
377   6          ELSE DO;
378   7              DELY=1;
379   7              DELX=1;
380   7          END;
381   6      END;
382   5      IF (Y=YC) THEN DO;
384   6          IF (X>XC) THEN DO;
386   7              DELX=-1;
387   7              DELY=1;
388   7              END;
389   6          ELSE DO;
390   7              DELX=1;
391   7              DELY=-1;
392   7              END;
393   6          END;
394   5          END;
395   4          LX=DELX*2*(X-XC)+1;
396   4          LY=DELY*2*(Y-YC)+1;
```

```
397   4      D=0;
398   4      DO WHILE (((X2=FX) OR (Y2=FY)
399   5          OR (((X1-FX)*(X2-FX)<0) AND ((Y1-FY)*(Y2-FY)<0))
400   5          OR (((X1-FX)*(X2-FX)>0) AND ((Y1-FY)*(Y2-FY)<0))
401   5          OR(((X1-FX)*(X2-FX)<0)AND((Y1-FY)*(Y2-FY)>0)AND(Y2*FY>0
402   5              -))) ;
403   5      D1=(D+LX); IF D1<0 THEN D1=-D1;
404   5      D2=(D+LY); IF D2<0 THEN D2=-D2;
405   5      D3=(D+LX+LY); IF D3<0 THEN D3=-D3;
406   5      IF (D1>D2)AND (D2>D3) THEN GOTO XYINC;
407   5      IF (D1>D2)AND (D2<=D3) THEN GOTO YINC;
408   5      IF D1>D3 THEN GOTO XYINC;
409   5      XYINC: D=D+LX;
410   5      LX=LX+2;
411   5      X=X+DELX;
412   5      CALL OUTCHAR(CHX);
413   5      GOTO CONTIN;

414   5      XYINC: D=D+LX+LY;
415   5      LX=LX+2;
416   5      LY=LY+2;
417   5      X=X+DELX;
418   5      Y=Y+DELY;
419   5      CALL OUTCHAR(CHX);
420   5      CALL OUTCHAR(CHY);
421   5      GOTO CONTIN;

422   5      YINC: D=D+LY;
423   5      LY=LY+2;
424   5      Y=Y+DELY;
425   5      CALL OUTCHAR(CHY);
426   5      CONTIN: X1=X2;
427   5      X2=X;
428   5      Y1=Y2;
429   5      Y2=Y;
430   5      END;

431   5      DO WHILE (X>FX);
432   5      CALL OUTCHAR(CHX);
433   5      X=X+DELX;
434   5      END;

435   5      DO WHILE (Y>FY);
436   4      CALL OUTCHAR(CHY);
437   5      Y=Y+DELY;
438   5      END;
```

```
444    4      END; /* Circular interpolation ends */
445    3      ELSE DO; /* Point to point , positioning */

446    4          IF DX=DY THEN F=DX;
447    4          ELSE IF DX>DY THEN DO;
448    5              CHXY=CHX;
449    5              F=DY;
450    5              END;
451    5          ELSE DO;
452    5              F=DX;
453    4              CHXY=CHY;
454    5              END;
455    5          DO DELX=1 TO F;
456    5              CALL OUTCHAR(CHX);
457    5              CALL OUTCHAR(CHY);
458    5          END;
459    5          IF DX=DY THEN GOTO OVER;
460    5          N=M-F-F;
461    4          DO DELX=1 TO N;
462    5              CALL OUTCHAR(CHXY);
463    5          END;
464    4      OVER: END; /* point to point positioning over */

465    3          CALL OUTCHAR(CR);
466    3          CALL OUTCHAR(LF);
467    3          CALL OUTCHAR('*&'); /* DELIMITER FOR PLOTTER DATA */
468    3          DO I=2 TO 6;
469    4              CODEPAST(I)=CODENOW(I);
470    4          END;

471    3      RET1:   END; /* END OF PROCEDURE MOVE */

472    2          /*ACTION STARTS HERE */
473    2          CODE=CODENOW(1);
474    2          SPEED=CODENOW(7);
475    2          TOOL=CODENOW(10);
476    2          IF SPEED<MAXSPEED THEN
477    2              SPEED=(SPEED/MAXSPEED)*256;
478    2          ELSE SPEED=MAXSPEED;
479    2          I=LOW(UNSIGN(SPEED));
480    2          P2CBUF=I;
481    2          OUTPUT(P2C)=I;
482    2          IF CODENOW(10) <> CODEPAST(10) THEN
483    2              DO;
484    2                  CALL OUTSTRING(@TOOLMESS);
485    2                  CALL OUTINTEGER(TOOL);
```

```
488   3           CODENOW(10)=CODEPAST(10);
489   3           END;
490   2           ELSE IF CODE=00 THEN LINEAR=FALSE; /* point to point */
492   2           ELSE IF CODE=01 THEN LINEAR=TRUE; /* linear interpolation */
494   2           ELSE IF (CODE=02)OR(CODE=03) THEN DO; /* circular interpolation */
496   3                           CIRCULAR=TRUE;
497   3                           IF CODE=02 THEN CWISE=TRUE;
498   3                           -ELSE CWISE=FALSE;
500   3           CALL MOVE;
501   3           END;
502   2           ELSE IF CODE=91 THEN INCREMENTAL=TRUE; /* incremental dimensioning */
504   2           ELSE IF CODE=90 THEN INCREMENTAL=FALSE; /* absolute dimensioning */
506   2           ELSE IF CODE=04 THEN CALL DELAY; /* dwell */
508   2           ELSE IF (CODE=28) OR (CODE=29) THEN
509   2               DO;
510   4                   DO I=2 TO 6; CODENOW(I)=0;
512   4                   END;
513   3                   CALL MOVE;
514   3                   END;
515   2           ELSE IF CODE=53 THEN CALL MOVE;
517   2           ELSE IF (CODE<>90) AND (CODE<>91) AND (CODE<>4) AND (CODE<>28) AND (CODE<>29) AND (CODE<>53) THEN CALL NOTIMPLEM;

519   2           DO I=2 TO 6;
520   3           IF NOT (CODENOW(I)=CODEPAST(I)) THEN CALL MOVE;
522   3           END;
523   2           MISC=CODENOW(9);

524   2           IF MISC=00 THEN CALL HOLD;
526   2           ELSE IF MISC=02 THEN GOTO EXIT; /*END OF PROGRAM*/
528   2           ELSE IF MISC=03 THEN DO;
529   3               /* CW ROTATION */
530   3               P2ABUF=(P2ABUF) AND (5FH);
531   3               OUTPUT(P2A)=P2ABUF;
532   3               END;

533   2           ELSE IF MISC=04 THEN DO;
534   3               /* CCW ROTATION */
535   3               P2ABUF=(P2ABUF) OR (80H);
536   3               P2ABUF=(P2ABUF) AND (ODFH);
```

```
537    3           OUTPUT(P2A)=P2ABUF;
538    3           END;
539    2   ELSE IF MISC=05 THEN DO;
540        /* STOP SPINDLE */
541        P2ABUF=(P2ABUF) OR (0AOH);
542        OUTPUT(P2A)=P2ABUF;
543        END;

544    2   ELSE IF MISC=06 THEN DO;
545        /* TOOL CHANGE */
546        CALL OUTSTRING(@TOOLMESS);
547        CALL OUTINTEGER(TOOL);
548        END;

549    2   ELSE IF MISC=07 THEN DO;
550        /* COOLANT ON */
551        P1ABUF=(P1ABUF) OR (COOLNT);
552        OUTPUT(P1A)=P1ABUF;
553        END;

554    2   ELSE IF MISC=09 THEN DO;
555        /* COOLANT OFF */
556        P1ABUF=(P1ABUF) AND (OFEH);
557        OUTPUT(P1A)=P1ABUF;
558        END;

559    2   ELSE IF MISC=10 THEN DO;
560        /* CLAMP */
561        P2ABUF= P2ABUF OR (10H);
562        OUTPUT(P2A)=P2ABUF;
563        END;

564    2   ELSE IF MISC=11 THEN DO;
565        /* UNCLAMP */
566        P2ABUF=P2ABUF AND (OEFH);
567        OUTPUT(P2A)=P2ABUF;
568        END;
569    2   ELSE IF (MISC<99) AND (MISC>11) THEN CALL NOTIMPLEM;
570        CODENOW(9)=99; /* MISC=99 */
571        CODEPAST(10)=CODENOW(10);
572        END; /* ACTION */

574    1   GET$NEW$CODE: PROCEDURE;
575    2   DIGIT$NO: PROCEDURE;
576    3   IF (CHAR>='0') AND (CHAR<='9') THEN II=CHAR-'0';
```

```
578   3     ELSE II=OFFH;
579   3     END;

580   2     CODE$COORD: PROCEDURE;
581   3     DECLARE MAX$DIGIT BYTE DATA (05H);
582   3     J=0; K=I;
583   3     M=0;
584   3     LOOP1: INDEX=INDEX+1;
585   3     CHAR=BUFFER(INDEX);
586   3     IF CHAR=0 THEN GOTO CONT1; /* buffer end */
587   3     IF CHK$VALID=TRUE THEN GOTO CONT1;
588   3     CALL DIGIT$NO; /* NOW II CONTAINS THE DIGIT VALUE */
589   3     IF (II=OFFH) then
590   3       if (CHAR<'+')AND(CHAR>'-') THEN GOTO CONT1;
591   4     IF CHAR='-' THEN DO; M=1; GOTO LOOP1; END;
592   3     IF CHAR='+' THEN GOTO LOOP1;
593   3     T(J)=INT(II);
594   3     J=J+1;
595   3     IF J<(MAX$DIGIT) THEN GOTO LOOP1;
596   3     INDEX=INDEX+1;
597   3     CONT1: DO CASE J;
598   4     . TEMP=0;
599   4     TEMP=T(0);
600   4     TEMP=T(0)*10+T(1);
601   4     TEMP=T(0)*100+T(1)*10+T(2);
602   4     TEMP=T(0)*1000+T(1)*100+T(2)*10+T(3);
603   4     TEMP=T(0)*10000+T(1)*1000+T(2)*100+T(3)*10+T(4);
604   4     END;
605   3     IF (M=01) THEN
606   3     TEMP=-TEMP;
607   3     END;

608   2     GET$NGSFTM: PROCEDURE;
609   3     J=0; K=I;
610   3     LOOP2: INDEX=INDEX+1;
611   3     CHAR=BUFFER(INDEX);
612   3     IF CHAR=0 THEN GOTO CONT2;
613   3     IF CHK$VALID=TRUE THEN GOTO CONT2;
614   3     CALL DIGIT$NO;
615   3     IF (II=OFFH) THEN IF (CHAR<'+') THEN GOTO CONT2;
616   3     T(J)=INT(II);
617   3     J=J+1;
618   3     IF (JKL) THEN GOTO LOOP2;
619   3     INDEX=INDEX+1;
620   3     CONT2: DO CASE J;
621   4     . TEMP=0;
622   4     TEMP=T(0);
```

```
639    4      TEMP=T(0)*10+T(1);
640    4      TEMP=T(0)*100+T(1)*10+T(2);
641    4      END;
642    3      END;

643    2      CODE$3: PROCEDURE; /* FOR N, S, F */
644    3      L=3;
645    3      CALL GET$NGSFTM;
646    3      END;

647    2      CODE$2: PROCEDURE; /* FOR G, T, M */
648    3      L=2;
649    3      CALL GET$NGSFTM;
650    3      END;

651    2      INDEX=0;
652    2      LP:CHAR=BUFFER(INDEX);
653    2      IF CHAR=0 THEN GOTO EX;
654    2      IF CHK$VALID=TRUE THEN
655        DO CASE I;
656        CALL CODE$3;
657        CALL CODE$2;
658        CALL CODE$COORD;
659        CALL CODE$COORD;
660        CALL CODE$COORD;
661        CALL CODE$COORD;
662        CALL CODE$COORD;
663        CALL CODE$COORD;
664        CALL CODE$3;
665        CALL CODE$3;
666        CALL CODE$2;
667        CALL CODE$COORD;
668        CALL CODE$COORD;
669        CALL CODE$COORD;
670        END; /*NOW TEMP CONTAINS THE INTEGER VALUE OF THE I
              -TH FUNCTION */

671    2      ELSE DO;
672    3      CALL OUT$STRING(@ERR5);
673    3      CALL OUT$STRING(@WARN);
674    3      INDEX=INDEX+1;
675    3      GOTO LP;
676    3      END;
677    2      CODE$PAST(K)=CODE$NOW(K);
678    2      CODE$NOW(K)=TEMP;
679    2      GOTO LP;
680    2      EX: END;

681    1      INIT$PLOTTER: PROCEDURE;
```

```
682    2      DECLARE PLTCHR(*) BYTE DATA (<&H&1,0);
683    2      CALL OUTSTRING(@PLTCHR);
684    2      END;

685    1      OUT$FILE: PROCEDURE;
686    2      DECLARE CH BYTE;
687    2      FILE$INDEX=0;
688    2      REPLP: CH=FILE$DATA(FILE$INDEX);
689    2      IF CH=0 THEN GOTO REPEX;
690    2      CALL OUTCHAR(CH);
691    2      IF CH='<' THEN DO;
692    3          CALL OUTCHAR(CR);
693    3          CALL OUTCHAR(LF);
694    3      END;
695    3      FILE$INDEX=FILE$INDEX+1;
696    2      GOTO REPLP;
697    2      REPEX: CALL OUTCHAR(CR);
698    2      CALL OUTCHAR(LF);
699    2      END;

700    1      START: CALL INITPORT;
701    1          CALL INITIALPORTS;
702    1          CALL INITIAL$8251;
703    1          CALL INITIAL$DATA;
704    1          CALL OUT$STRING(@SIGN$ON);
705    1          CALL OUTCRLF;
706    1          LOOP: CALL STORE$FILE;
707    1          CONTIN: CALL OUT$FILE;
708    1              CALL INITIAL$DATA;
709    1              CALL INIT$PLOTTER;
710    1              ACT$LOOP: CALL GET$DATA;
711    1              EXT$LOOP: CALL GET$NEW$CODE;
712    1                  CALL ACTION;
713    1                  GOTO ACT$LOOP;

714    1          EXIT: CALL OUT$STRING(@MESS4);
715    1              CALL GETCHAR;
716    1              IF CHAR='N' THEN GOTO LOOP;
717    1              IF CHAR='C' THEN GOTO CONTIN;
718    1              GOTO EXIT;
719    1          CTLZ: CALL OUTSTRING(@ABORT);
720    1          GOTO START;
721    1      END; /*MAIN PROGRAM*/
```

CROSS-REFERENCE LISTING

DEFN	ADDR	SIZE	NAME, ATTRIBUTES, AND REFERENCES
4	002BH	16	ABORT. BYTE ARRAY(16) DATA 723
202	0493H	785	ACTION PROCEDURE STACK=001AH 714
712	0025H		ACTLOOP. LABEL 715
13			BKSPCE LITERALLY '08H' 150
13			BLANK. LITERALLY '20H' 67 161
128	0506H	1	BLK. BYTE IN PROC (STOREFILE) 131* 167* 167
17	FHFFFF0H	1	BOOT1. BYTE ARRAY(1) AT INITIAL A -BSOLUTE
17	FHFFF1H	2	BOOT2. WORD ARRAY(1) AT INITIAL A -BSOLUTE
17	FHFFF3H	2	BOOT3. WORD ARRAY(1) AT INITIAL A -BSOLUTE
296	09B4H		BOTH LABEL IN PROC (MOVE) 284
14	0479H	128	BUFFER BYTE ARRAY(128) 100* 103* 110* 586 622 652
686	050DH	1	CH BYTE IN PROC (OUTFILE) 688* 689 691 692
56	0004H	1	CH BYTE IN PROC (OUTCHAR) PAR -AMETER AUTOMATIC 56 61
9	0090H	1	CHAR BYTE 66* 67 68 69 89 135 137 140 142 145 147 150 156 161 163 165 170 188* 189 190 194* 195 199 576 577 586* 587 593 595 600 622* 623 629 652* 653 718 720
50	0112H	28	CHARRDY. PROCEDURE BYTE STACK=0002H 57 192
187	043EH	85	CHKCTLCHAR PROCEDURE STACK=0006H 58
87	01CFH	54	CHKVALID PROCEDURE BYTE STACK=0002H

231	050AH	1	CHX.	589 625 655 BYTE IN PROC (MOVE) 265* 266* 289 298 417 424 437 450 458
231	050CH	1	CHXY	BYTE IN PROC (MOVE) 288* 289* 291 450* 455* 465
231	050BH	1	CHY.	BYTE IN PROC (MOVE) 268* 269* 288 309 425 430 441 455 459
20	04FFH	1	CIRCULAR	BYTE 117* 322 496*
12			CMNDS251	LITERALLY '025H' 47
203	004EH	2	CODE	INTEGER IN PROC (ACTION) 475* 490 492 494 497 502 504 506 508 515 517
647	12B2H	13	CODE2.	PROCEDURE IN PROC (GETNEWC -ODE) STACK=000AH 658 666 667
643	12A5H	13	CODE3.	PROCEDURE IN PROC (GETNEWC -ODE) STACK=000AH 657 664 665
580	1039H	392	CODECOORD.	PROCEDURE IN PROC (GETNEWC -ODE) STACK=0006H 659 660 661 662 663 668 669
14	0026H	26	CODENOW.	INTEGER ARRAY(13) 122* 124* 125* 221 224* 239 240 241 244 245 246 324 325 330 331 398 431 432* 433 434* 472 475 476 477 484 488* 511* 520 523 571* 572 677 678*
14	000CH	26	CODEPAST	INTEGER ARRAY(13) 121* 224 239 240 241 326 327 328 329 398 431* 433* 472* 484 488 520 572* 677*

607	10ECH		CONT1	LABEL IN PROC (CODECOORD) 588 590 594
634	1245H		CONT2	LABEL IN PROC (GETNGSFTM) 624 626 630
431	0DEFH		CONTIN	LABEL IN PROC (MOVE) 418 426
709	001CH		CONTIN	LABEL 721
21			COOLNT	LITERALLY '01H' 551
3			CR	LITERALLY '0DH' 4 5 69 73 161 468 694 699
723	0062H		CTLZ	LABEL 196 200
20	0500H	1	CWISE.	BYTE 118* 362 498* 499*
233	0086H	2	D.	INTEGER IN PROC (MOVE) 397* 399 402 405 414* 414 419* 419 427* 427
233	0080H	2	D1	INTEGER IN PROC (MOVE) 399* 400 401* 401 408 410 412
233	0082H	2	D2	INTEGER IN PROC (MOVE) 402* 403 404* 404 408 410
233	0084H	2	D3	INTEGER IN PROC (MOVE) 405* 406 407* 407 412
12			DATA8251	LITERALLY '0FFF0H' 61 66 188 194
219	07E2H	55	DELAY.	PROCEDURE IN PROC (ACTION) - STACK=0002H 507
13			DELETE	LITERALLY '010H' 150
232	0068H	2	DELX	INTEGER IN PROC (MOVE) 281* 306 333* 334* 343* 347* 354* 358* 365* 366* 375* 379* 386* 390* 395 416 422 438 457* 457 460 464* 464 466
232	006AH	2	DELY	INTEGER IN PROC (MOVE) 282* 317 336* 337* 342* 346* 355* 359*

					368* 369* 374* 378*
					387* 391* 396 423
					429 442
8	017DH	10	DIGIT		BYTE ARRAY(10) DATA
575	1011H	40	DIGITNO.		PROCEDURE IN PROC (GETNEWC ODE) STACK=0002H
					591 627
321	0A6BH		DONE		LABEL IN PROC (MOVE)
					286 295 303 314
12			DSRDY.		LITERALLY '080H'
228	0058H	2	DX		INTEGER IN PROC (MOVE)
					239* 244* 248 251*
					251 274 282 283
					285 287 296 304
					446 447 448 454
					461
228	005AH	2	DY		INTEGER IN PROC (MOVE)
					240* 245* 253 256*
					256 274 281 283
					285 296 315 446
					448 451 461
228	005CH	2	DZ		INTEGER IN PROC (MOVE)
					241* 246* 258 261*
					261
13			EOB.		LITERALLY '3BH'
4	003BH	25	ERR1		BYTE ARRAY(25) DATA
					217
4	0054H	24	ERR2		BYTE ARRAY(24) DATA
6	013AH	27	ERR5		BYTE ARRAY(27) DATA
					672
680	100FH		EX		LABEL IN PROC (GETNEWCODE)
					654
716	0036H		EXIT		LABEL 98 527
					722
713	0028H		EXTLOOP.		LABEL 105
232	0062H	2	F.		INTEGER IN PROC (MOVE)
					275* 306* 306 307
					317* 317 318 447*
					451* 454* 457 463
5			FALSE.		LITERALLY '000H'
					52 92 117 234
					235 236 237 362
					491 499 505
11	0091H	1000	FILEDATA		BYTE ARRAY(1000)
					97 99 100 101

			137*	142*	147*	158*
			165*	182*	688	
			WORD		97	99
10	000AH	2 FILEINDEX	100	101	108*	108
			111*	111	114*	129*
			138*	138	143*	143
			148*	148	152*	152
			153	154*	166	168*
			168	172*	178	687*
			688	697*	697	
9	008FH	1 FL	BYTE		97	104*
233	0078H	2 FX	119*			
233	007AH	2 FY	INTEGER IN PROC (MOVE)			
			330*	398	436	
			INTEGER IN PROC (MOVE)			
			331*	398	440	
63	0158H	56 GETCHAR	PROCEDURE STACK=000CH			
			134	717		
94	0205H	109 GETDATA	PROCEDURE STACK=0002H			
			712			
574	0F3CH	213 GETNEWCODE	PROCEDURE STACK=0016H			
			713			
618	11C1H	228 GETNGSFTM	PROCEDURE IN PROC (GETNEWC			
			-ODE) STACK=0006H			
			645	649		
210	07BAH	28 HOLD	PROCEDURE IN PROC (ACTION)			
			- STACK=0002H			
			525			
9	0088H	1 I.	BYTE	88*	88	
			89	91	120*	120
			123	211*	212*	212
			213	471*	471	472
			473	481*	482	483
			510*	510	512	519*
			519	520	522	583
			620	656		
			INTEGRER IN PROC (MOVE)			
233	006CH	2 II	324*	326		
					577*	578*
9	008EH	1 II	BYTE			
			592	602	628	631
			BYTE		115*	237
20	04FDH	1 INCREMENTAL	503*	505*		
			BYTE IN PROC (GETDATA)			
95	0505H	1 IND.	96*	107*	107	
			BYTE IN PROC (OUTSTRING)			
79	0504H	1 IND.	80*	81	82	83*

				83
15	04F9H	1	INDEX	BYTE 585* 585 586 606* 606 621* 621 622 635* 635 651* 652 674* 674
38	00B5H	93	INITIAL8251 . . .	PROCEDURE STACK=0002H 704
113	0272H	88	INITIALDATA . . .	PROCEDURE STACK=0002H 705 710
31	0096H	31	INITIALPORTS . . .	PROCEDURE STACK=0002H 703
681	12BFH	12	INITPLOTTER . . .	PROCEDURE STACK=0016H 711
23	0071H	37	INITPORT	PROCEDURE STACK=0002H 702
			INPUT	BUILTIN 51 59 64 66 188 194 211
			INT	BUILTIN 602 631
2	0000H	10	INTVECTOR	POINTER ARRAY(5)
9	0089H	1	J.	BYTE 582* 603* 603 604 607 619* 632* 632 633 636
233	006EH	2	JJ	INTEGER IN PROC (MOVE) 325* 327
9	008AH	1	K.	BYTE 583* 620* 677
9	008BH	1	L.	BYTE 633 644* 648*
			LAST	BUILTIN 88
3			LF	LITERALLY '0AH' 4 5 74 161 469 695 700
180	0187H	35	LIMITERR	BYTE ARRAY(35) IN PROC (ST -OREFILE) DATA 181
20	04FEH	1	LINEAR	BYTE 116* 279 491* 493*
708	0019H		LOOP	LABEL 719
134	02EAH		LOOP	LABEL IN PROC (STOREFILE) 162 185
585	104FH		LOOP1	LABEL IN PROC (CODECOORD) 598 601 605
621	11D1H		LOOP2	LABEL IN PROC (GETNGSFTM)

				83
15	04F9H	1	INDEX	BYTE 585* 585 586 606* 606 621* 621 622 635* 635 651* 652 674* 674
38	00B5H	93	INITIAL8251 . . .	PROCEDURE STACK=0002H 704
113	0272H	88	INITIALDATA . . .	PROCEDURE STACK=0002H 705 710
31	0096H	31	INITIALPORTS . . .	PROCEDURE STACK=0002H 703
681	12BFH	12	INITPLOTTER . . .	PROCEDURE STACK=0016H 711
23	0071H	37	INITPORT	PROCEDURE STACK=0002H 702 BUILTIN 51 59 64 66 188 194 211
			INPUT	BUILTIN 602 631
			INT	
2	0000H	10	INTVECTOR	POINTER ARRAY(5)
9	0089H	1	J	BYTE 582* 603* 603 604 607 619* 632* 632 633 636
233	006EH	2	JJ	INTEGER IN PROC (MOVE) 325* 327
9	008AH	1	K	BYTE 583* 620* 677
9	008BH	1	L	BYTE 633 644* 648*
			LAST	BUILTIN 88
3			LF	LITERALLY '0AH' 4 5 74 161 469 695 700
180	0187H	35	LIMITERR	BYTE ARRAY(35) IN PROC (STOREFILE) DATA 181
20	04FEH	1	LINEAR	BYTE 116* 279 491* 493*
708	0019H		LOOP	LABEL 719
134	02EAH		LOOP	LABEL IN PROC (STOREFILE) 162 185
585	104FH		LOOP1	LABEL IN PROC (CODECOORD) 598 601 605
621	11D1H		LOOP2	LABEL IN PROC (GETNGSFTM)

			LOW	634 BUILTIN 481 LABEL IN PROC (GETNEWCODE) 675 679
652	0F44H		LP	WORD IN PROC (STOREFILE) 130* 166* 172
128	004CH	2	LSTBLK	INTEGER IN PROC (MOVE) 395* 399 405 414
233	007CH	2	LX	415* 415 419 420*
				420 INTEGER IN PROC (MOVE) 396* 402 405 419
233	007EH	2	LY	421* 421 427 428*
				428 INTEGER IN PROC (MOVE) 274* 290 302 313
232	005EH	2	M.	463 BYTE 584* 597*
9	008CH	1	M.	615 BYTE IN PROC (CODECOORD) D
581	01CBH	1	MAXDIGIT	-ATA 604
204	0000H	2	MAXSPEED	INTEGER IN PROC (ACTION) D -ATA 478 479
				480 BYTE ARRAY(52) DATA 132
5	006CH	52	MESS1.	BYTE ARRAY(52) DATA 133
5	00A0H	52	MESS2.	BYTE ARRAY(51) DATA 176
5	00D4H	51	MESS3.	BYTE ARRAY(51) DATA 716
5	0107H	51	MESS4.	INTEGER IN PROC (ACTION) 523* 524 526 528
203	0050H	2	MISC	533 539 544 549 554 559 564 569
				LITERALLY 'OCFH'
12			MODE8251	45 PROCEDURE IN PROC (ACTION)
226	0819H	1827	MOVE	- STACK=000CH 500 513 516 521
232	0064H	2	MX	INTEGER IN PROC (MOVE) 276* 301* 301 304
232	0066H	2	MY	INTEGER IN PROC (MOVE)

232	0060H	2	N.	277*	312*	312	315
													INTEGER IN PROC (MOVE)			
													278*	290	293*	293
													300*	300	302	311*
													311	313	463*	464
9	008DH	1	N.	BYTE			
220	0056H	2	N.	WORD IN PROC (DELAY)			
													221*	221	223	
	0000H	113	NCM.	PROCEDURE STACK=001CH			
216	07D6H	12	NOTIMPLEM.	PROCEDURE IN PROC (ACTION)			
													- STACK=0016H			
													518	570		
206	0004H	2	NUMBER	INTEGER IN PROC (OUTINTEGE			
													-R) PARAMETER AUTOMATIC			
55	012EH	42	OUTCHAR.	PROCEDURE STACK=0008H			
													68	73	74	82
													263	271	272	273
													291	298	309	417
													424	425	430	437
													441	458	459	465
													468	469	470	691
													694	695	699	700
72	0190H	17	OUTCRLF.	PROCEDURE STACK=000CH			
													70	85	173	707
685	12CBH	81	OUTFILE.	PROCEDURE STACK=000CH			
													709			
205	07A4H	22	OUTINTEGER	PROCEDURE IN PROC (ACTION)			
													- STACK=0004H			
													487	547		
													BUILTIN			24*
													28*	29*	32*	34*
													36*	39*	41*	43*
													45*	47*	61*	208*
													483*	531*	537*	542*
													552*	557*	562*	567*
76	01A1H	46	OUTSTRING.	PROCEDURE STACK=0012H			
													132	133	176	181
													217	486	546	672
													673	683	706	716
													723			
467	0F00H		OVER	LABEL IN PROC (MOVE)			
21			P1A.	462			
22	0501H	1	P1ABUF	LITERALLY '0FFF9H'			
													28	552	557	
													BYTE		25*	28

					551* 551 552 556*
					556 557
21		P1B.	.	.	LITERALLY '0FFFFBH'
					211
22	0502H	1	P1BBUF	.	BYTE 26*
21			P1C.	.	LITERALLY '0FFFFDH'
					29 208
22	0503H	1	P1CBUF	.	BYTE 27* 29
					207* 208
21		P1S.	.	.	LITERALLY '0FFFFFH'
					24
19		P2A.	.	.	LITERALLY '0FFF8H'
					34 531 537 542
					562 567
18	04FAH	1	P2ABUF	.	BYTE 33* 34
					530* 530 531 535*
					535 536* 536 537
					541* 541 542 561*
					561 562 566* 566
					567
19		P2B.	.	.	LITERALLY '0FFF9H'
18	04FBH	1	P2BBUF	.	BYTE
19			P2C.	.	LITERALLY '0FFFCH'
					36 483
18	04FCH	1	P2CBUF	.	BYTE 35* 36
					482*
19		P2S.	.	.	LITERALLY '0FFE9H'
					32
682	01CCH	4	PLTCHR	.	BYTE ARRAY(4) IN PROC (INI -TPLOTTER) DATA
					683
77	0004H	2	PTR.	.	POINTER IN PROC (DUTSTRING -) PARAMETER AUTOMATIC
					77 81 82
211	07BDH		REP.	.	LABEL IN PROC (HOLD)
					214
699	130EH		REPEX.	.	LABEL IN PROC (OUTFILE)
					690
688	12D4H		REPLP.	.	LABEL IN PROC (OUTFILE)
					698
12			RESET8251.	.	LITERALLY '065H'
					43
474	0F3AH		RET1	.	LABEL IN PROC (MOVE)
12			RXRDY.	.	LITERALLY '02H'
					51 64
13			SCRNBBLNK	.	LITERALLY '0CH'

4	0002H	41	SIGNON	BYTE ARRAY(41) DATA 706
229	0507H	1	SIGNX.	BYTE IN PROC (MOVE) 234* 250* 264
229	0508H	1	SIGNY.	BYTE IN PROC (MOVE) 235* 255* 267
229	0509H	1	SIGNZ.	BYTE IN PROC (MOVE) 236* 260* 270
203	0052H	2	SPEED.	INTEGER IN PROC (ACTION) 476* 478 479* 479 480* 481
702	0003H		START.	LABEL 724
17			STARTADDR.	LITERALLY '0000H' 17
12			STAT8251	LITERALLY '0FFF2H' 39 41 43 45 47 51 59 64
127	02CAH	372	STOREFILE.	PROCEDURE STACK=0016H 708
78	0000H	1	STR.	BYTE BASED(PTR) ARRAY(1) I -N PROC (OUTSTRING) 81 82
14	0040H	10	T.	INTEGER ARRAY(5) INITIAL 602* 609 610 611 612 613 631* 638 639 640
16	004AH	2	TEMP	INTEGER 608* 609* 610* 611* 612* 613* 616* 616 637* 638* 639* 640* 678
			TIME	BUILTIN 40 42 44 46 48 222 292 299 310
203	0054H	2	TOOL	INTEGER IN PROC (ACTION) 477* 487 547
203	01AAH	33	TOOLMESS	BYTE ARRAY(33) IN PROC (AC -TION) DATA 486 546
5			TRUE	LITERALLY '0FFH' 53 90 115 116 118 250 255 260 493 496 498 503 589 625 655
12			TXRDY.	LITERALLY '01H'
			UNSIGN	BUILTIN 207

CROSS-REFERENCE LISTING

				481
7	0170H	13	VALIDFN	BYTE ARRAY(13) DATA 88 89
6	0155H	27	WARN	BYTE ARRAY(27) DATA 673
233	0074H	2	X.	INTEGER IN PROC (MOVE) 328* 335 338 352 367 370 384 395 416* 416 422* 422 432 436 438* 438
227			X1	LITERALLY 'CODEPAST(2)' IN -N PROC (MOVE) 239 326 328 398 431
227			X2	LITERALLY 'CODENOW(2)' IN - PROC (MOVE) 239 244 330 398 431
298	09C4H		XALSO.	LABEL IN PROC (MOVE) 308 316 320
233	0070H	2	XC	INTEGER IN PROC (MOVE) 326* 335 338 352 367 370 384 395
414	0D76H		XINC	LABEL IN PROC (MOVE)
230			XMINUS	LITERALLY '30H' IN PROC -MOVE) 265
230			XPLUS.	LITERALLY '50H' IN PROC -MOVE) 266
419	0D96H		XYINC.	LABEL IN PROC (MOVE) 409 413
233	0076H	2	Y.	INTEGER IN PROC (MOVE) 329* 332 340 350 364 372 382 396 423* 423 429* 429 434 440 442* 442
227			Y1	LITERALLY 'CODEPAST(3)' -N PROC (MOVE) 240 327 329 398 432
227			Y2	LITERALLY 'CODENOW(3)' - PROC (MOVE) 240 245 331 398 433
309	0A16H		YALSO.	LABEL IN PROC (MOVE) 297 305 319
233	0072H	2	YC	INTEGER IN PROC (MOVE)

			327*	332	340	350
			364	372	382	396
427	0DD2H	YINC	LABEL IN PROC (MOVE)			
			411			
230		YMINUS	LITERALLY ^20H^ IN PROC			
			-MOVE)			268
230		YPLUS.	LITERALLY ^40H^ IN PROC			
			-MOVE)			269
227		Z1	LITERALLY ^CODEPAST(4)^			
			-N PROC (MOVE)			
227		Z2	241			
			LITERALLY ^CODENOW(4)^			
			- PROC (MOVE)			
			241	246		

MODULE INFORMATION:

CODE AREA SIZE	= 131CH	4892D
CONSTANT AREA SIZE	= 01D0H	464D
VARIABLE AREA SIZE	= 050EH	1294D
MAXIMUM STACK SIZE	= 001CH	28D
798 LINES READ		
0 PROGRAM WARNINGS		
0 PROGRAM ERRORS		

END OF PL/M-86 COMPIRATION

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